Montana Department of
ENVIRONMENTAL QUALITY
Brian Schweitzer, Governor
P. O. Box 200901 Helena, MT 59620-0901 (406) 444-2544 Website: www.deq.mt.gov

March 24, 2009

Eric Ervin
Plant Manager
Holcim (US) Inc.
4070 Trident Road
Three Forks, MT 59752

RE: Decision Title V Operating Permit #OP0982-02

Dear Mr. Ervin:

The Department of Environmental Quality has prepared the enclosed Decision Operating Permit #OP0982-02, for Holcim (US) Inc., located in Three Forks, Montana. Please review the cover page of the attached permit for information pertaining to the action taking place on Permit #OP0982-02.

If you have any questions, please contact Skye Hatten, the permit writer, at (406) 444-5287 or by email at shatten@mt.gov.

Sincerely,

Vickie Walsh
Air Permitting Program Supervisor
Air Resources Management Bureau
(406) 444-9741

Skye Hatten, P.E.
Environmental Engineer
Air Resources Management Bureau
(406) 444-5287

VW: SH: ob
Enclosure

Cc: Christopher Ajayi, US EPA Region VIII 8P-AR
Betsy Burns, US EPA Region VIII, Montana Office
Greg Gannon, 4070 Trident Road, Three Forks, MT 59752

State of Montana
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT NUMBER OP0982-02

Minor Modification Application Received: November 10, 2008
Application Deemed Administratively Complete:December 10, 2008
Application Deemed Technically Complete: January 6, 2009
AFS Number: 030-031-0005A

Proposed Issue Date: February 6, 2009
End of EPA 45-day Review: March 23, 2009
Date of Decision: March 24, 2009
Effective Date: April 24, 2009
Expiration Date: April 24, 2014

In accordance with the Montana Code Annotated (MCA) Sections 75-2-217 and 218, and the Administrative Rules of Montana (ARM) Title 17, Chapter 8, Subchapter 12, Operating Permit Program, ARM 17.8.1201, *et seq*.,

Holcim (US), Inc.
NE ¼ Section 9, SE ¼ Section 4, SW ¼ Section 3, NW ¼ Section 10, Township 2 North, Range 2 East, Gallatin County
4070 Trident Road
Three Forks, MT 59752

hereinafter, referred to as "Holcim", is authorized to operate a stationary source of air contaminants consisting of the emission units described in this permit. Until this permit expires or is modified or revoked, Holcim is allowed to discharge air pollutants in accordance with the conditions of this permit. All conditions in this permit are federally and state enforceable unless otherwise specified. Requirements which are state only enforceable are identified as such in the permit. A copy of this permit must be kept on site at the above named facility.

Permit Issuance and Appeal Process: In accordance with Section 75-2-218, MCA, the Department of Environmental Quality's (Department) decision regarding issuance of an operating permit is not effective until 30 days have elapsed from the date of the decision issued March 24, 2009. The decision may be appealed to the Board of Environmental Review (Board) by filing a request for a hearing within 30 days after the date of decision. The filing of a request for hearing does not stay the Department's decision, unless the Board orders a stay upon receipt of a petition and a finding that a stay is appropriate under Section 75-2-218(6)(b), MCA. If no stay is ordered, the Department's decision on the application is final 30 days after the decision is made and the Department will send notification and a final permit cover page to be attached to this document stating that the permit is final. In addition, ARM 17.8.1233 allows for any person to petition the Environmental Protection Agency (EPA) within 60 days after the expiration of EPA's 45-day review period to object to issuance of this operating permit. If EPA objects to the operating permit as a result of a petition prior to the Department's notification of a final permit, Holcim and all affected parties will be informed of the stay of a final permit. If the Department has already notified Holcim and all affected parties, the Department shall issue a revised permit according to ARM 17.8.1231. Questions regarding the final issuance date and status of appeals should be directed to the Department at (406) 444-3490.

Montana Air Quality Operating Permit
Department of Environmental Quality

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit have the meaning assigned to them in the referenced regulations.

SECTION I. GENERAL INFORMATION

The following general information is provided pursuant to ARM 17.8.1210(1).

Company Name: **Holcim (US), Inc.**

Mailing Address: **4070 Trident Road**

City: **Three Forks** State: **MT** Zip: **59752**

Plant Location: **NE ¼ Section 9, SE ¼ Section 4, SW ¼ Section 3, NW ¼ Section 10, Township 2 North, Range 2 East, Gallatin County, MT**

Responsible Official: **Eric Ervin, Plant Manager** Phone: **(406) 285-3985**

Facility Contact Person: **Greg Gannon, Environmental Manager** Phone: **(406) 285-4977**

Primary SIC Code: **3241 (plant), 1422 (quarry)**

Nature of Business: **Portland Cement Manufacturing**

Description of Process:

The production of Portland cement begins at the quarry. Most of the raw material used in the cement process is combined high and low-grade limestone quarried from Holcim's quarry. Limestone rock and other raw materials are blasted and loaded onto trucks and transported to the crusher or to stockpiles. The raw materials are conveyed from the primary and secondary crushers to the storage bins.

From the storage bins, the raw materials are conveyed to the ball mill where the ore is ground with water to form slurry and is then sent to storage tanks. In the tanks, the slurry is blended thoroughly before entering the kiln.

The slurry is pumped to the uphill end of the kiln where the slurry is heated, evaporating water (H_2O) from the slurry and turning it into clinker. The plant uses a combination of natural gas, coal and/or coke as fuel sources for the clinker production.

When the clinker leaves the kiln, it is cooled, transported by drag chains, pan conveyor and bucket elevator to the clinker bins or outside storage. From the clinker bins, clinker and gypsum go to the "finish" ball mills, where it is ground to produce portland cement. The final cement product is conveyed to storage silos where it is loaded into railroad cars or bulk trucks.

SECTION II. SUMMARY OF EMISSION UNITS

The emission units regulated by this permit are the following (ARM 17.8.1211):

Emissions Unit ID	Description	Pollution Control Device/Practice
EU001	Fugitive Emissions: Disturbed Areas	None
EU003	Quarry Blasting	None
EU005	Raw Material Transfer and Conveying	Baghouses
EU006	Raw Material Storage Piles	Water and/or Chemical Dust Suppressant
EU007	Fugitive Emissions: Haul Roads	Water and/or Chemical Dust Suppressant
EU008	Primary Crusher	Baghouse
EU009	Crusher Screen	Baghouse
EU010	Raw Material Silo #1 Loading & Unloading	Baghouse
EU011	Raw Material Silos #2 & #3 Loading & Unloading	Baghouse
EU012	Raw Material Silos #4 & #5 Loading & Unloading	Baghouse
EU013	Raw Material Silos #6 & #7 Loading & Unloading	Baghouse
EU014	Coal/Coke Unloading	Baghouse
EU015	Coal Transfer	Baghouse
EU018	Coal/Coke Primary Crusher	Baghouse
EU019	Coal Silo Loading & Unloading & Secondary Crushing	Baghouse
EU020	Coke Silo Loading & Unloading, & Secondary Crushing	Baghouse
EU021	Kiln	ESP
EU022	Clinker Cooler	Baghouse
EU023	Inside Clinker Transfer from Cooler	Baghouse
EU024	Clinker Storage Silo #1, #2, & Interstice Bin Load/Unload	Baghouse
EU025	Cement Kiln Dust Silo Loading	Baghouse
EU026	Cement Kiln Dust Silo Unloading to Truck	Water and/or Chemical Dust Suppressant
EU027	Outside Clinker Bins Loading	Baghouse
EU028-031	Outside Clinker Storage Silos 1-4	None
EU032	#2 Finish Mill	Baghouse
EU033	Clinker Transfer to #2 Finish Mill & #3 Finish Mill	Baghouse
EU034	#3 Finish Mill	Baghouse
EU035	Clinker Transfer to #4 Finish Mill	Baghouse
EU036	#4 Finish Mill Product Separator	Baghouse
EU037	#4 Finish Mill	Baghouse
EU038	Dust Discharge Spout between Kiln and Precipitator	Baghouse
EU040	Import Clinker Unloading & Transfer	Baghouse
EU041	Gypsum Unloading & Transfer	Baghouse
EU043	Outside Clinker Transfer to Reclaim Building	Baghouse
EU044	Cement Loaded/Unloaded at Silos #1-7, 10, 11, & 13	2 Baghouses
EU045	Cement Loaded/Unloaded at Silos #8, 9 , & 12	2 Baghouses
EU046	Cement Transferred form Silos #1-13 to Bulk Load Silos #14-25	Baghouse
EU047	Cement Loaded/Unloaded at Silos #14-25	2 Baghouse
EU048	Cement Loaded/Unloaded at Silos #26-30	Baghouse
EU049-050	Bulk Cement Truck Transfer/Loadouts 1 & 2	2 Baghouses
EU051	Bulk Cement Railcar Transfer/Loadouts 1 & 2	Baghouse
EU053	CKD and Flyash Transfers to/from Pozzolan Silo	Baghouse
EU054	Landfilled Cement Kiln Dust Handling	None
EU055	Material Handling System for Feeding the Finish Mills	3 Baghouses
EU059	Post Consumer Recycled Glass Transfers	None
EU060	Overflow Gypsum Transfer to Ground	None
EU061	Overflow Gypsum Transfer to Reclaim Building	Feed Hopper Enclosed in Building
EU062	CKD Recycle Dust Scoops	2 Baghouses

SECTION III. PERMIT CONDITIONS

The following requirements and conditions are applicable to the facility or to specific emission units located at the facility (ARM 17.8.1211, 1212, and 1213).

A. Facility-Wide

Conditions	Rule Citation	Rule Description	Pollutant/Parameter	Limit
A.1	ARM 17.8.105	Testing Requirements	Testing Requirements	-------
A.2	ARM 17.8.304(1)	Visible Air Contaminants	Opacity	40%
A.3	ARM 17.8.304(2)	Visible Air Contaminants	Opacity	20%
A.4	ARM 17.8.308(1)	Particulate Matter, Airborne	Fugitive Opacity	20%
A.5	ARM 17.8.308(2)	Particulate Matter, Airborne	Reasonable Precautions	-------
A.6	ARM 17.8.308	Particulate Matter, Airborne	Reasonable Precaution, Construction	20%
A.7	ARM 17.8.309	Particulate Matter, Fuel Burning Equipment	Particulate Matter	$E= 0.882 * H^{-0.1664}$ Or $E= 1.026 * H^{-0.233}$
A.8	ARM 17.8.310	Particulate Matter, Industrial Processes	Particulate Matter	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11}- 40$
A.9	ARM 17.8.322(4)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (liquid or solid fuels)	1 lb/MMBtu fired
A.10	ARM 17.8.322(5)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (gaseous)	50 gr/100 CF
A.11	ARM 17.8.324(3)	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks	-------
A.12	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	65,000 Gallon Capacity	-------
A.13	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	Oil-effluent Water Separator	-------
A.14	ARM 17.8.340	New Source Performance Standards	All Applicable Provisions of Subparts F & Y	-------
A.15	ARM 17.8.342	NESHAPs General Provisions	SSM Plans	Submittal
A.16	ARM 17.8.749	Permit Conditions, Facility Clinker Handling	Operational Limit	500,000 tons/rolling 12-Month Period of Clinker Handled
A.17	40 CFR 63	National Emission Standards for Hazardous Air Pollutants	All Applicable Provisions of Subpart LLL	------
A.18	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-------
A.19	ARM 17.8.1207	Reporting Requirements	Annual Certification	-------

Conditions

A.1. Pursuant to ARM 17.8.105, any person or persons responsible for the emission of any air contaminant into the outdoor atmosphere shall, upon written request of the Department, provide the facilities and necessary equipment (including instruments and sensing devices) and shall conduct test, emission or ambient, for such periods of time as may be necessary using methods approved by the Department.

Compliance demonstration frequencies that list "as required by the Department" refer to ARM 17.8.105. In addition, for such sources, compliance with limits and conditions listing "as required by the Department" as the frequency, is verified annually using emission factors and engineering calculations by the Department's compliance inspectors during the annual emission inventory review; in the case of Method 9 tests, compliance is monitored during the regular inspection by the compliance inspector.

A.2. Pursuant to ARM 17.8.304(1), Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.3. Pursuant to ARM 17.8.304(2), Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.4. Pursuant to ARM 17.8.308(1), Holcim shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.5. Pursuant to ARM 17.8.308(2), Holcim shall not cause or authorize the use of any street, road or parking lot without taking reasonable precautions to control emissions of airborne particulate matter, unless otherwise specified by rule or in this permit.

A.6. Pursuant to ARM 17.8.308, Holcim shall not operate a construction site or demolition project unless reasonable precautions are taken to control emissions of airborne particulate matter. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.7. Pursuant to ARM 17.8.309, unless otherwise specified by rule or in this permit, Holcim shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

For new fuel burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu.

A.8. Pursuant to ARM 17.8.310, unless otherwise specified by rule or in this permit, Holcim shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10 * P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0 * P^{0.11} - 40$

Where E = rate of emissions in pounds per hour and p = process weight rate in tons per hour.

A.9. Pursuant to ARM 17.8.322(4), Holcim shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per million BTU fired, unless otherwise specified by rule or in this permit.

A.10. Pursuant to ARM 17.8.322(5), Holcim shall not burn any gaseous fuel containing sulfur compounds in excess of 50 grains per 100 cubic feet of gaseous fuel, calculated as hydrogen sulfide at standard conditions, unless otherwise specified by rule or in this permit.

A.11. Pursuant to ARM 17.8.324(3), Holcim shall not load or permit the loading of gasoline into any stationary tank with a capacity of 250 gallons or more from any tank truck or trailer, except through a permanent submerged fill pipe, unless such tank is equipped with a vapor loss control device or is a pressure tank as described in ARM 17.8.324(1), unless otherwise specified by rule or in this permit.

A.12. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, Holcim shall not place, store or hold in any stationary tank, reservoir or other container of more than 65,000 gallon capacity any crude oil, gasoline or petroleum distillate having a vapor pressure of 2.5 pounds per square inch absolute or greater under actual storage conditions, unless such tank, reservoir or other container is a pressure tank maintaining working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation.

A.13. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, Holcim shall not use any compartment of any single or multiple-compartment oil-effluent water separator, which compartment receives effluent water containing 200 gallons a day or more of any petroleum product from any equipment processing, refining, treating, storing or handling kerosene or other petroleum product of equal or greater volatility than kerosene, unless such compartment is equipped with a vapor loss control device, constructed so as to prevent emission of hydrocarbon vapors to the atmosphere, properly installed, in good working order and in operation.

A.14. Holcim shall comply with all applicable provisions, as appropriate, of 40 CFR 60, Subpart F – Standards of Performance for Portland Cement Plants and Subpart Y – Standards of Performance for Coal Preparation Plants (ARM 17.8.340, and 40 CFR 60, Subpart F and Y).

A.15. Pursuant to ARM 17.8.342 and 40 CFR 63.6, Holcim shall submit to the Department a copy of any startup, shutdown, and malfunction (SSM) plan required under 40 CFR 63.6(e)(3) within 30 days of the effective date of this operating permit (if not previously submitted), within 30 days of the compliance date of any new National Emission Standard for Hazardous Air Pollutants (NESHAPs) or Maximum Achievable Control Technology (MACT) standard, and within 30 days of the revision of any such SSM plan, when applicable. The Department requests submittal of such plans in electronic form, when possible.

A.16. Holcim shall limit clinker handling to 500,000 tons during any rolling 12-month period (ARM 17.8.749).

A.17. Holcim shall comply with all applicable provisions of 40 CFR 63, Subpart LLL – National Emission Standards for Hazardous Air Pollutants from the Portland Cement Manufacturing Industry. In 2000, the Trident facility was designated an area source for the purpose of determining the applicability of Portland Cement Maximum Achievable Control Technology (PC MACT). The compliance date for an owner or operator of an existing affected source subject to the provisions of Subpart LLL was June 14, 2002. Holcim shall comply with 40 CFR 63, Subpart LLL, which includes but is not limited to:

a. Notification to the Department within 15 days of a significant change in raw material or fuel;

b. Preparation of a written operations and maintenance plan for the kiln (40 CFR 63.6); and

c. Development and implementation of a written startup, shutdown, and malfunction plan (40 CFR 63.6).

A.18. On or before February 15 and August 15 of each year, Holcim shall submit to the Department the compliance monitoring reports required by Section V.D. These reports must contain all information required by Section V.D, as well as the information required by each individual emissions unit. For the reports due by February 15 of each year, Holcim may submit a single report, provided that it contains all the information required by Section V.B & V.D. Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including semiannual monitoring reports), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that,* ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

A.19. By February 15 of each year, Holcim shall submit to the Department the compliance certification required by Section V.B. The annual certification required by Section V.B must include a statement of compliance based on the information available which identifies any observed, documented or otherwise known instance of noncompliance for each applicable requirement. Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including annual certifications), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that,* ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

B. Emitting Units – EU001 Fugitive Emissions: Disturbed Areas
EU003 Quarry Blasting

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
B.1, B.2, B.3, B.4, B.5, B.6, B.7	Opacity	20%	Method 9	As required by the Department and Section III.A.1.	Semiannual
			Visual Surveys	Weekly	Semiannual

Conditions

B.1. Holcim shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of airborne particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.308(1)).

Compliance Demonstration

B.2. Once per calendar week during daylight hours, Holcim shall visually survey emissions from the emitting units for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to be any visible emissions, which meet or exceed 15% opacity. The

person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous 2 years of the visual survey being performed. If sources of visible emissions are identified, Holcim shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Holcim shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Holcim of a liability for a violation determined using Method 9.

Method 9 tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must be a minimum of 20 minutes or until a violation of the standard has been documented, whichever is a shorter period of time (ARM 17.8.106 and ARM 17.8.1213).

Recordkeeping

B.3. Holcim shall maintain a log to verify that the visual surveys were performed as specified in Section III.B.2. Each log entry must include the date, time, results of the survey, and observer's initials. Whether visual surveys or Method 9 tests are conducted, if any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log (ARM 17.8.1212).

B.4. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

B.5. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

B.6. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

B.7. The semiannual monitoring report shall provide (ARM 18.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period; and

b. Certification that the visual surveys were performed and logged as required in Sections III.B.2 and III.B.3.

c. Identify any instances of excessive fugitive emissions and provide a summary of any corrective action taken.

C. Emitting Units – EU006 Raw Material Storage Piles
EU007 Fugitive Emissions: Haul Roads

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.1, C.3, C.4, C.5, C.6, C.7, C.8	Opacity	20%	Method 9	As required by the Department and Section III.A.1.	Semiannual
			Visual Survey	Weekly	
C.2, C.3, C.4, C.7, C.8	Airborne Particulate Matter	Reasonable Precaution	Water and/or Chemical Dust Suppressants	As Needed	Semiannual

Conditions

C.1. Holcim shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of airborne particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.308(1)).

C.2. Holcim shall not cause or authorize the use of any street, road, or parking lot without taking reasonable precautions to control emissions of airborne particulate matter (ARM 17.8.308(2)).

Compliance Demonstration

C.3. Once per calendar week during daylight hours, Holcim shall visually survey emissions from the emitting units for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to be any visible emissions, which meet or exceed 15% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous 2 years of the visual survey being performed. If sources of visible emissions are identified, Holcim shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Holcim shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Holcim of a liability for a violation determined using Method 9.

Method 9 tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must be a minimum of 20 minutes or until a violation of the standard has been documented, whichever is a shorter period of time (ARM 17.8.106 and ARM 17.8.1213).

Recordkeeping

C.4. Holcim shall maintain, on site, a log to verify that the visual surveys were performed as specified in Section III.C.3. Each log entry must include the date, time, results of the survey, and observer's initials. Whether visual surveys or Method 9 tests are conducted, if any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log (ARM 17.8.1212).

C.5. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

C.6. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

C.7. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

C.8. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the visual surveys were performed and logged as required in Sections III.C.3 and III.C.4; and

c. Identify any instances of excessive fugitive emissions and provide a summary of any corrective action taken.

D. Emitting Units – EU008 Primary Crusher
EU009 Crusher Screen

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.1, D.5, D.9, D.12, D.13, D.14	Opacity	20%	Method 9	Every 5 years	Semiannual
D.2, D.6, D.9, D.12, D.13, D.14	Particulate Matter	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11}- 40$	Method 5	Every 5 years	Semiannual
D.3, D.7, D.10, D.13, D.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse(s)	Whenever Process Equipment is Operating	Semiannual
D.4, D.8, D.11, D.13, D.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

D.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibits an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)).

D.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 4.10 * P^{0.67}$ for process weight rates up to 30 tons per hour and/or $E = 55.0 * P^{0.11} – 40$ for process weight rates in excess of 30 tons per hour, where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

D.3. Holcim shall operate and maintain baghouse(s) to control emissions from the emitting units (ARM 17.8.749).

D.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

D.5. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.D.1 by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

D.6. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.D.2 by performing a Method 5 test, or another test method approved by the Department, once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

D.7. Holcim shall monitor compliance with Section III.D.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

D.8. Holcim shall monitor compliance with Section III.D.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

D.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

D.10. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse(s) in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

D.11. Holcim shall maintain the records required by Section III.D.8 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

D.12. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

D.13. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

D.14 The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse(s) were operated, inspected, and maintained as required by Sections III.D.3 and III.D.7; and

c. Certification that the documentation required in Section III.D.8 was maintained.

E. Emitting Units – EU005 Raw Materials Transfer and Conveying
EU010 Raw Material Silo #1: Loading & Unloading
EU011 Raw Material Silos #2 and #3: Loading & Unloading
EU012 Raw Material Silos #4 and #5: Loading & Unloading
EU013 Raw Material Silos #6 and #7: Loading & Unloading

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
E.1, E.5, E.9, E.12, E.13, E.14	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
E.2, E.6, E.9, E.12, E.13, E.14	Particulate Matter	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11}- 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
E.3, E.7, E10, E13, E.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse(s)	Whenever Process Equipment is Operating	Semiannual
E.4, E.8, E.11, E.13, E.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

E.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibits an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)).

E.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 4.10 * P^{0.67}$ for process weight rates up to 30 tons per hour and/or $E = 55.0 * P^{0.11} – 40$ for process weight rates in excess of 30 tons per hour, where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

E.3. Holcim shall operate and maintain baghouse(s) to control emissions from the emitting units (ARM 17.8.749).

E.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

E.5. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.E.1 by performing a Method 9 test as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

E.6. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.E.2 by performing a Method 5 test, or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

E.7. Holcim shall monitor compliance with Section III.E.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

E.8. Holcim shall monitor compliance with Section III.E.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

E.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

E.10. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse(s) in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

E.11. Holcim shall maintain the records required by Section III.E.8 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

E.12. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

E.13. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements ARM 17.8.1212.

E.14 The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse(s) were operated, inspected, and maintained as required by Sections III.E.3 and III.E.7; and

c. Certification that the documentation required in Section III.E.8 was maintained.

F. Emitting Units – EU014 Coal/Coke Unloading
EU015 Coal Transfer
EU018 Coal/Coke Primary Crusher
EU019 Coal Silo Loading & Unloading, and Secondary Crushing
EU020 Coke Silo Loading & Unloading, and Secondary Crushing

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.1, F.6, F.9, F.12, F.13	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse(s)	Whenever Process Equipment is Operating	Semiannual
F.2, F.4, F.8, F.11, F.12, F.13	Opacity	20%	Method 9	Every 5 years	Semiannual
F.2, F.5, F.8, F.11, F.12, F.13	Particulate Matter	0.02 gr/dscf	Method 5	Every 5 years	Semiannual
F.3, F.7, F.10, F.12, F.13	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

F.1. Holcim shall operate and maintain baghouse(s) to control emissions from the following coal and coke handling equipment (ARM 17.8.752):

a. Screw conveyor from the coal/coke crusher to the bucket elevator;

b. “Raw” coke storage silo, 290-ton;

d. Coke storage silo;

e. Two diverter valves;

f. Hammermill;

g. Bucket elevator;

h. Coal storage silo;

i. Belt conveyor with weighing system at the base of the “raw” coke storage silo;

j. Coke grinding mill; and

k. “Fine” coke storage silo, 220-ton.

F.2. Holcim shall not cause or authorize to be discharged into the atmosphere from the coal and coke handling baghouse(s):

a. Particulate matter in excess of 0.02 grains per dry standard cubic foot (gr/dscf) (ARM 17.8.752); and

b. Visible emissions that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304).

F.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

F.4. Holcim shall monitor compliance with the 20% opacity limit in contained in Section III.F.2 by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

F.5. Holcim shall monitor compliance with the particulate emission limitation in Section III.F.2 by performing a Method 5 test or another test method approved by the Department once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

F.6. Holcim shall monitor compliance with Section III.F.1 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

F.7. Holcim shall monitor compliance with Section III.F.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

F.8. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

F.9. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

F.10. Holcim shall maintain the records required by Section III.F.7 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

F.11. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

F.12. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

F.13. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse(s) were operated, inspected, and maintained as required by Sections III.F.1 and III.F.6; and
c. Certification that the documentation required in Section III.F.7 was maintained.

G. Emission Unit – EU021 Kiln

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.1, G.13, G.25, G.27, G.31, G.33, G.34, G.35	Opacity	20%	Continuous Monitor	Ongoing	Semiannual
G.2, G.14, G.26, G.33, G.34, G.35	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of ESP	Whenever Process Equipment is Operating	Semiannual
G.3, G.15, G.27, G.31, G.33, G.34, G.35	Particulate Matter	0.77 lb/ton of Clinker	Method 5	Annually	Semiannual
G.4, G.16, G.27, G.31, G.33, G.34, G.35	Sulfur Dioxide	As Allowed in ARM 17.8.322(6)(c)	Method 6	Every 5 years	Semiannual
G.5, G.17, G.27, G.28, G.29, G.31, G.33, G.34, G.35	Sulfur Dioxide	124 lb/hr averaged over any rolling 30-Day Period	Continuous Monitor	Ongoing	Semiannual
G.6, G.18, G.28, G.33, G.34, G.35	Fuel Usage	100% Natural Gas, 100% Coal, 100% Coke, or Any Combination of These Fuels	Recordkeeping	Monthly	Semiannual
G.7, G.19, G.28, G.33, G.34, G.35	Clinker Operational Limit	425,000 tons/rolling 12-Month Period	Recordkeeping	Monthly	Semiannual
G.8, G.20, G.27, G.28, G.31, G.32, G.33, G.34, G.35	Dioxins/Furans	0.20 or 0.40 ng per dscm Corrected to 7% Oxygen—depending on avg. temp of source tests	Method 23	Every 30 Months	Semiannual
			Inspection of Combustion Components	Annual	Annual
G9, G.21, G.29, G.32, G.33, G.34, G.35	Operational Limit	Inlet Temperatures to PMCD	Continuous Monitor	Ongoing	Semiannual
G.10, G.22, G.27, G28, G.29, G.31, G.33, G.34, G.35	Nitrogen Oxide	1,568 lb/hr averaged over any rolling 30-Day Period	Continuous Monitor	Ongoing	Semiannual
G.11, G.23, G.29, G.33, G.34, G.35	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual
G.12, G.24, G.30, G.34, G.35	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

G.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibits an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)).

G.2. Holcim shall operate and maintain an electrostatic precipitator (ESP) to control kiln emissions (ARM 17.8.749).

G.3. Particulate emissions from the kiln are limited to 0.77 pound per ton (lb/ton) of clinker produced (ARM 17.8.749).

G.4. Holcim shall comply with the sulfur in fuel rule (ARM 17.8.322(6)(c)).

G.5. Holcim shall not cause or authorize to be discharged into the atmosphere from the kiln any gases that contain sulfur dioxide (SO_2) in excess of 124 pounds per hour (lb/hr) averaged over any rolling 30-day period (ARM 17.8.749).

G.6. In the cement kiln, Holcim is authorized to burn up to 100% natural gas, up to 100% coal, up to 100% coke, or any combination of these fuels within the previously stated limits (ARM 17.8.749).

G.7. Holcim shall limit kiln production to 425,000 tons of clinker during any rolling 12-month period (ARM 17.8.749).

G.8. Holcim shall not cause to be discharged into the atmosphere from the kiln any gases that contain dioxins and furans in excess of:

a. 0.20 ng per dscm ($8.7x10^{-11}$ gr/dscf)(TEQ) corrected to 7% oxygen; or

b. 0.40 ng per dscm ($1.7x10^{-10}$ gr/dscf) (TEQ) corrected to 7% oxygen, when the average of the performance test run average temperatures at the inlet to the particulate matter control device is 204^{o} C (400^{o} F) or less (40 CFR 63.1343).

G.9. Holcim shall operate the kiln such that the temperature of the gas at the inlet of the kiln particulate matter control device (PMCD) does not exceed the appropriate temperature limit specified in 40 CFR 63.1344(b), as applicable (40 CFR 63.1344 and 40 CFR 63.6).

G.10. Holcim shall not cause or authorize to be discharged into the atmosphere from the kiln any gases that contain NO_x in excess of 1,568 lb/hr averaged over any rolling 30-day period (ARM 17.8.749).

G.11. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

G.12. Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the emitting unit by following the Compliance Assurance Monitoring (CAM) plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

G.13. Within 180 days after Permit #OP0982-02 becomes final, Holcim shall monitor compliance with Section III.G.1 by installing, calibrating, operating, and maintaining a Continuous Opacity Monitoring System (COMS) in accordance with Appendix B to 40 CFR 60, Performance Specification 1. In addition, Holcim shall inspect and audit the COMS annually, using neutral

density filters. Holcim shall conduct these audits using the applicable procedures and forms in the EPA Technical Assistance Document: Performance Audit Procedures for Opacity Monitors (EPA-450/4-92-010, April 1992) (ARM 17.8.1213).

G.14. Holcim shall monitor compliance with Section III.G.2 by inspecting and maintaining the ESP in accordance with Appendix E of this permit (ARM 17.8.1213).

G.15. Holcim shall monitor compliance with Section III.G.3 by annually conducting a Method 5 test or another test method approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

G.16. Holcim shall monitor compliance with Section III.G.4 by conducting a Method 6 test or another test method approved by the Department once every 5 years. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

G.17. Holcim shall monitor compliance with Section III.G.5 by documenting, by day, the lb/hr amount of SO_2 emissions discharged into the atmosphere from the kiln. Total SO_2 emissions shall be calculated from 7:00 a.m. to 7:00 a.m. on a daily basis and averaged over 30-day rolling time periods. In addition, Holcim shall monitor compliance with Section III.G.5 by calibrating, maintaining, and operating Continuous Emission Monitoring System (CEM) monitors. The CEMs must be operated while the kiln is operating and must measure the SO_2 emissions, including the volumetric flow rate. These CEMs shall complete one cycle of operation (sampling, analyzing, and data recording) for each successive 15-minute period. The performance specification procedures conducted by Holcim must conform to 40 CFR part 60, Appendix B, Specification 2 and 6 and be approved by the Department. On-going quality assurance requirements must conform to 40 CFR Part 60, Appendix F (ARM 17.8.749 and ARM 17.8.1213).

G.18. Holcim shall maintain a log of the daily amount of coal, natural gas, and coke used in the kiln to demonstrate compliance with the limit in Section III.G.6. The log must be maintained on site and must be submitted to the Department upon request (ARM 17.8.1213).

G.19. Holcim shall document, by month, the amount of clinker produced in the kiln. By the 25^{th} day of each month, Holcim shall total the amount of clinker produced during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.G.7. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.749 and ARM 17.8.1213).

G.20. Holcim shall monitor compliance with Section III.G.8 by conducting a Method 23 (40 CFR 60, Appendix A) performance test every 30 months. Holcim shall repeat the performance test for the kiln within 90 days of initiating any significant change in the feed or fuel from that used in the previous performance test (40 CFR 63.1349 and ARM 17.8.1213). In addition, Holcim shall conduct an inspection of the components of the combustion system of the kiln at least once per year (40 CFR 63.1350 and ARM 17.8.1213).

G.21. Holcim shall monitor compliance with Section III.G.9 by calibrating, maintaining, and operating a monitor to record the temperature of the exhaust gases from the kiln for monitoring Dioxin/Furan emissions. The calibration of all thermocouples and other temperature sensors required by 40 CFR 63.1350 shall be verified at least once every 3 months (40 CFR 63.1350 and ARM 17.8.1213).

G.22. Holcim shall monitor compliance with Section III.G.10 by documenting, by day, the lb/hr amount of NO_x emissions discharged into the atmosphere from the kiln. Total NO_x emissions shall be calculated from 7:00 a.m. to 7:00 a.m. on a daily basis and averaged over rolling 30-day time periods (ARM 17.8.749 and 17.8.1213). In addition, Holcim shall monitor compliance with Section III.G.10 by calibrating, maintaining, and operating CEM monitors. The CEMS must be operated while the kiln is operating and must measure the NO_x emissions, including the volumetric flow rate. These CEMs shall complete one cycle of operation (sampling, analyzing, and data recording) for each successive 15-minute period. The performance specification procedures conducted by Holcim must conform to 40 CFR par 60, Appendix B, Specification 2 and 6 and be approved by the Department. On-going quality assurance requirements must conform to 40 CFR Part 60, Appendix F (ARM 17.8.1213).

G.23. Holcim shall monitor compliance with Section III.G.11 by documenting that conveyor covers, transfer point conveyors, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

G.24. Holcim shall monitor compliance with Section III.G.12 by monitoring emissions according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

G.25. Holcim shall maintain a file of all measurements from the COMS, and performance testing measurements; all COMS performance evaluations; all COMS or monitoring device calibration checks and audits; and adjustments and maintenance performed on these systems or devices, recorded in a permanent form suitable for inspection. The file shall be retained on site for at least 5 years following the date of such measurements and reports. Holcim shall supply these records to the Department upon request (ARM 17.8.1212).

G.26. Holcim shall maintain records of all inspection and maintenance activities performed on the ESP in accordance with Appendix E of this permit. All inspection and maintenance records must be maintained on site and must be submitted to the Department upon request (ARM 17.8.1212).

G.27. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

G.28. Holcim shall maintain records as required by Sections III.G.17, III.G.18, III.G.19, III.G.20, III.G.22, and III.G.23 on site and submit the information to the Department upon request (ARM 17.8.1212).

G.29. Holcim shall maintain calibration records as required by Sections III.G.17, III.G.21, and III.G.22 on site and submit the information to the Department upon request (ARM 17.8.1212).

G.30. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

G.31. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

G.32. Holcim shall submit a summary report semiannually, which contains the information specified in 40 CFR 63.10(e)(3)(vi). In addition, the summary report shall include:

a. All exceedances of maximum control device inlet gas temperature limits;

b. All failures to calibrate thermocouples and other temperature sensors required by 40 CFR 63.1350;

c. The results of any combustion system component inspections conducted within the reporting period; and

d. All failures to comply with any provision of the operation and maintenance plan (40 CFR 63.1354).

G.33. If any action taken by Holcim during a startup, shutdown, or malfunction is not consistent with the procedures specified in the affected source's startup, shutdown, and malfunction plan, Holcim shall record the actions taken for that event and shall report such actions within 2 working days after commencing actions inconsistent with the plan, followed by a letter within 7 working days after the end of the event (40 CFR 63.6(e)(3)).

G.34. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

G.35. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the ESP was operated, inspected, and maintained as required by Sections III.G.2 and III.G.14;

c. Certification that the COMS was installed, calibrated, operated, and maintained as required by Section III.G.13.

d. Certification that the tests required in Sections III.G.15, III.G.16, and III.G.20 were conducted;

e. Certification that the documents required in Sections III.G.17, III.G.18, III.G.19, III.G.20, III.G.21, III.G.22, III.G.23, III.G.25, and III.G.26 were maintained;

f. A summary of the amount of post-consumer recycled glass used in the kiln for the semiannual period;

g. A summary of the amount of clinker produced for the semiannual period;

h. Annual certification that the written report required in Section III.G.32 was submitted; and

i. Certification that the CAM Plan contained in Appendix F of this permit was followed.

Kiln Alternate Operating Scenario #1
Firing Post-Consumer Recycled Container Glass

The use of post-consumer recycled container glass as a raw material substitute in the cement kiln shall be considered an alternative-operating scenario pursuant to ARM 17.8.1215. When the revisions to ARM 17.8.316, adopted by the Board of Environmental Review and effective on July 8, 1997, are incorporated into the State Implementation Plan (SIP), the applicability of the version of ARM 17.8.316 currently in the SIP will no longer be federally enforceable and this alternative operating scenario will no longer be applicable.

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.36, G.51, G.64, G.66, G.70, G.72, G.73, G.74	Opacity	10%	Continuous Monitor	Ongoing	Semiannual
G.37, G.51, G.64, G.66, G.70, G.72, G.73, G.74	Opacity	20%	Continuous Monitor	Ongoing	Semiannual
G.38, G.52, G.65, G.72, G.73, G.74	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of ESP	Whenever Process Equipment is Operating	Semiannual
G.39, G.53, G.66, G.70, G.72, G.73, G.74	Particulate Matter	0.10 gr/dscf of Dry Flue Gas, Adjusted to 12% CO_2 & Calculated (no Auxiliary Fuel Had Been Used)	Method 5	As Required by the Department and Section III.A.1	Semiannual
G.40, G.53, G.66, G.70, G.72, G.73, G.74	Particulate Matter	0.77 lb/ton of Clinker	Method 5	As Required by the Department and Section III.A.1	Semiannual
G.41, G.54, G.66, G.70, G.72, G.73, G.74	Sulfur Dioxide	As Allowed in ARM 17.8.322(6)(c)	Method 6	As Required by the Department and Section III.A.1	Semiannual
G.42, G.55, G.66, G.67, G.68, G.70, G.72, G.73, G.74	Sulfur Dioxide	124 lb/hr averaged over any rolling 30-Day Period	Continuous Monitor	Ongoing	Semiannual
G.43, G.56, G.67, G.72, G.73, G.74	Post-Consumer Recycled Container Glass Operational Limit	800 tons/rolling 12-Month Period	Recordkeeping	When Using Glass	Semiannual
G.44, G.57, G.67, G.72, G.73, G.74	Clinker Operational Limit	425,000 tons/rolling 12-Month Period	Recordkeeping	Monthly	Semiannual
G.45, G.58, G.66, G.67, G.70, G71 G.72, G.73, G.74	Dioxins/Furans	0.20 or 0.40 ng per dscm Corrected to 7% Oxygen—depending on avg. temp of source tests	Method 23	As Required by the Department and Section III.A.1	Semiannual
			Inspection of Combustion Components	Annual	Semiannual
G.46, G.59, G.68, G.71, G.72, G.73, G.74	Operational Limit	Inlet Temperatures to PMCD	Continuous Monitor	Ongoing	Semiannual

G.47, G.60, G.66, G.67, G.68, G.70, G.72, G.73, G.74	Nitrogen Oxide	1,568 lb/hr averaged over any rolling 30-Day Period	Continuous Monitor	Ongoing	Semiannual
G.48, G.61, G.67, G.72, G.73, G.74	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Annual
G.49, G.62, G.67, G.72, G.73, G.74	Recordkeeping	Log Operating Scenario When Switching from One Scenario to Another	Reporting	As Required by the Department	Semiannual
G.50, G.63, G.69, G.73, G.74	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

G.36. Holcim shall not cause or authorize to be discharged into the outdoor atmosphere, emissions that exhibit an opacity of 10% or greater averaged over 6 consecutive minutes (ARM 17.8.316).

G.37. Holcim may not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)) (State Enforceable Only Until SIP Approval).

G.38. Holcim shall operate and maintain an ESP to control kiln emissions (ARM 17.8.749) (State Enforceable Only Until SIP Approval).

G.39. Holcim shall not cause or authorize to be discharged into the outdoor atmosphere, particulate matter in excess of 0.10 gr/dscf of dry flue gas, adjusted to 12% carbon dioxide and calculated as if no auxiliary fuel had been used (ARM 17.8.316).

G.40. Particulate matter emissions from the kiln are limited to 0.77 lb/ton of clinker produced (ARM 17.8.749).

G.41. Holcim shall comply with the sulfur in fuel rule (ARM 17.8.322(6)(c)).

G.42. Holcim shall not cause or authorize to be discharged into the atmosphere from the kiln any gases that contain SO_2 in excess of 124 lb/hr averaged over any rolling 30-day period (ARM 17.8.749).

G.43. Holcim is limited to 800 tons of post-consumer glass fired in the cement kiln during any rolling 12-month period (ARM 17.8.752).

G.44. Holcim shall limit kiln production to 425,000 tons of clinker during any rolling 12-month period (ARM 17.8.749).

G.45. Holcim shall not cause to be discharged into the atmosphere from the kiln any gases that contain dioxins and furans in excess of:

a. 0.20 ng per dscm ($8.7x10^{-11}$ gr per dscf)(TEQ) corrected to 7% oxygen; or

b. 0.40 ng per dscm (1.7x10-10 gr per dscf) (TEQ) corrected to 7% oxygen, when the average of the performance test run average temperatures at the inlet to the particulate matter control device is 204° C (400° F) or less (40 CFR 63.1343).

G.46. Holcim shall operate the kiln such that the temperature of the gas at the inlet of the kiln PMCD does not exceed the appropriate temperature limit specified in 40 CFR 63.1344(b), as applicable (40 CFR 63.1344 and 40 CFR 63.6).

G.47. Holcim shall not cause or authorize to be discharged into the atmosphere from the kiln any gases that contain NO_x in excess of 1,568 lb/hr averaged over any rolling 30-day period (ARM 17.8.749).

G.48. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749)

G.49. When making a change from one operating scenario to another, Holcim shall contemporaneously record, in a log at the permitted facility, a record of the operating scenario under which the facility is operating (ARM 17.8.1215).

G.50. Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the emitting unit by following the CAM plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

G.51. Within 180 days after Permit #OP0982-02 becomes final, Holcim shall monitor compliance with Section III.G.36 and Section III.G.37 by installing, calibrating, operating, and maintaining a COMS in accordance with Appendix B to 40 CFR 60, Performance Specification 1. In addition, Holcim shall inspect and audit the COMS annually, using neutral density filters. Holcim shall conduct these audits using the applicable procedures and forms in the EPA Technical Assistance Document: Performance Audit Procedures for Opacity Monitors (EPA-450/4-92-010, April 1992) (ARM 17.8.1213).

G.52. Holcim shall monitor compliance with Section III.G.38 by inspecting and maintaining the ESP in accordance with Appendix E of this permit (ARM 17.8.1213).

G.53. Holcim shall monitor compliance with Section III.G.39 and III.G.40 by conducting a Method 5 test or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

G.54. Holcim shall monitor compliance with Section III.G.41 by conducting, as required by the Department, a Method 6 test or another test method approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

G.55. Holcim shall monitor compliance with Section III.G.39 by documenting, by day, the lb/hr amount of SO_2 emissions discharged into the atmosphere from the kiln. Total SO_2 emissions shall be calculated from 7:00 a.m. to 7:00 a.m. on a daily basis and averaged over 30-day rolling time periods. In addition, Holcim shall monitor compliance with Section III.G.39 by calibrating, maintaining, and operating CEM monitors. The CEMs must be operated while the kiln is operating and must measure the SO_2 emissions, including the volumetric flow rate. These CEMs shall complete one cycle of operation (sampling, analyzing, and data recording) for each successive 15-minute period. The performance specification procedures conducted by Holcim must conform to 40 CFR par 60, Appendix B, Specification 2 and 6 and be approved by the Department. On-going quality assurance requirements must conform to 40 CFR Part 60, Appendix F (ARM 17.8.749 and ARM 17.8.1213).

G.56. Holcim shall document, by month, the amount of post-consumer recycled container glass used in the kiln. By the 25th day of each month, Holcim shall total the amount of recycled glass used for the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.G.43. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.749 and ARM 17.8.1213).

G.57. Holcim shall document, by month, the amount of clinker produced in the kiln. By the 25th day of each month, Holcim shall total the amount of clinker produced during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.G.44. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.749 and ARM 17.8.1213).

G.58. Holcim shall monitor compliance with Section III.G.45 by conducting a Method 23 (40 CFR 60, Appendix A) performance test every 30 months. Holcim shall repeat the performance test for the kiln within 90 days of initiating any significant change in the feed or fuel from that used in the previous performance test (40 CFR 63.1349 and ARM 17.8.1213). In addition, Holcim shall conduct an inspection of the components of the combustion system of the kiln at least once per year (40 CFR 63.1350 and ARM 17.8.1213).

G.59. Holcim shall monitor compliance with Section III.G.46 by calibrating, maintaining, and operating a monitor to record the temperature of the exhaust gases from the kiln for monitoring Dioxin/Furan emissions. The calibration of all thermocouples and other temperature sensors required by 40 CFR 63.1350 shall be verified at least once every 3 months (40 CFR 63.1350 and ARM 17.8.1213).

G.60. Holcim shall monitor compliance with Section III.G.47 by documenting, by day, the lb/hr amount of NO_x emissions discharged into the atmosphere from the kiln. Total NO_x emissions shall be calculated from 7:00 a.m. to 7:00 a.m. on a daily basis and averaged over rolling 30-day time periods (ARM 17.8.749 and 17.8.1213). In addition, Holcim shall monitor compliance with Section III.G.47 by calibrating, maintaining, and operating CEM monitors. The CEMs must be operated while the kiln is operating and must measure the NO_x emissions, including the volumetric flow rate. These CEMs shall complete one cycle of operation (sampling, analyzing, and data recording) for each successive 15-minute period. The performance specification procedures conducted by Holcim must conform to 40 CFR par 60, Appendix B, Specification 2 and 6 and be approved by the Department. On-going quality assurance requirements must conform to 40 CFR Part 60, Appendix F (ARM 17.8.749 and ARM 17.8.1213).

G.61. Holcim shall monitor compliance with Section III.G.48 by documenting that conveyor covers, transfer point conveyors, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

G.62. Holcim shall monitor compliance with Section III.G.49 by recording, in a log, the date and time when Holcim switches to or from using post-consumer recycled glass in the kiln within 24 hours of making a change from one operating scenario to another. The log shall be maintained as a permanent business record for at least 5 years following the activity, shall be available to the Department for inspection, and shall be submitted to the Department upon request (ARM 17.8.1213).

G.63. Holcim shall monitor compliance with Section III.G.50 by monitoring emissions according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

G.64. Holcim shall maintain a file of all measurements from the COMS, and performance testing measurements; all COMS performance evaluations; all COMS or monitoring device calibration checks and audits; and adjustments and maintenance performed on these systems or devices, recorded in a permanent form suitable for inspection. The file shall be retained on site for at least 5 years following the date of such measurements and reports. Holcim shall supply these records to the Department upon request (ARM 17.8.1212).

G.65. Holcim shall maintain records of all inspection and maintenance activities performed on the ESP in accordance with Appendix E of this permit. All inspection and maintenance records must be maintained on site and must be submitted to the Department upon request (ARM 17.8.1212).

G.66. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

G.67. Holcim shall maintain records as required by Sections III.G.55, III.G.56, III.G.57, III.G.58, III.G.60, III.G.61, and III.G.62 on site and submit the information to the Department upon request (ARM 17.8.1212).

G.68. Holcim shall maintain calibration records as required by Sections III.G.55, III.G.59, and III.G.60 on site and submit the information to the Department upon request (ARM 17.8.1212).

G.69. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

G.70. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

G.71. Holcim shall submit a summary report semiannually, which contains the information specified in 40 CFR 63.10(e)(3)(vi). In addition, the summary report shall include:

a. All exceedances of maximum control device inlet gas temperature limits;

b. All failures to calibrate thermocouples and other temperature sensors required by 40 CFR 63.1350;

c. The results of any combustion system component inspections conducted within the reporting period; and

d. All failures to comply with any provision of the operation and maintenance plan (40 CFR 63.1354).

G.72. If any action taken by Holcim during a startup, shutdown, or malfunction is not consistent with the procedures specified in the affected source's startup, shutdown, and malfunction plan, Holcim shall record the actions taken for that event and shall report such actions within 2 working days after commencing actions inconsistent with the plan, followed by a letter within 7 working days after the end of the event (40 CFR 63.6(e)(3)).

G.73. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

G.74. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the ESP was operated, inspected, and maintained as required by Section III.G.38;

c. Certification that the COMS was installed, calibrated, operated, and maintained as required by Section III.G.51.

d. Certification that any tests required in Sections III.G.53, III.G.54, and III.G.58 were conducted;

e. Certification that documents required in Sections III.G.55, III.G.56, III.G.57, III.G.58, III.G.59, III.G.60, III.G.61, III.G.64, and III.G.65 were maintained;

f. A summary of the amount of post-consumer recycled glass used in the kiln for the semiannual period;

g. A summary of the amount of clinker produced for the semiannual period;

h. Annual Certification that the written report required in Section III.G.71 was submitted; and

i. Certification that the CAM Plan contained in Appendix F of this permit was followed.

H. Emitting Unit – EU022 Clinker Cooler

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
H.1, H.7, H.13, H.17, H.18, H.19	Opacity	20%	Method 9	Every 5 years	Semiannual
H.2, H.8, H.13, H.17, H.18, H.19	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	Every 5 years	Semiannual
H.3, H.9, H.14, H.18, H.19	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
H.4, H.10, H.15, H.18, H.19	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual
H.5, H.11, H.15, H.18, H.19	Operational Limit	500,000 tons/rolling 12-Month Period Clinker Handled	Recordkeeping	Monthly	Semiannual
H.6, H.12, H.16, H.18, H.19	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

H.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

H.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

H.3. Holcim shall operate and maintain a baghouse to control emissions from the emitting unit (ARM 17.8.749).

H.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

H.5. Holcim shall limit clinker handling to 500,000 tons during any rolling 12-month period (ARM 17.8.749).

H.6 Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the emitting unit by following the CAM plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

H.7. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.H.1 by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

H.8. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.H.2 by performing a Method 5 test or another test method approved by the Department once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

H.9. Holcim shall monitor compliance with Section III.H.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

H.10. Holcim shall monitor compliance with Section III.H.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

H.11. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.H.5. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

H.12. Holcim shall monitor compliance with Section III.H.6 by monitoring emissions according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

H.13. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

H.14. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

H.15. Holcim shall maintain records as required by Sections III.H.10 and III.H.11 on site and submit the information to the Department upon request (ARM 17.8.1212).

H.16. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

H.17. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

H.18. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

H.19 The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Sections III.H.3 and III.H.9;

c. Certification that the documents required in Section III.H.10 were maintained;

d. A summary of the amount of clinker handled during the semiannual period; and

e. Certification that the CAM Plan contained in Appendix F of this permit was followed.

I. Emitting Unit – EU023 Inside Clinker Transfer from Cooler

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
I.1, I.6, I.11, I.14, I.15, I.16	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
I.2, I.7, I.11, I.14, I.15, I.16	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
I.3, I.8, I.12, I.15, I.16	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
I.4, I.9, I.13, I.15, I.16	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual
I.5, I.10, I.13,	Operational Limit	500,000 tons/rolling	Recordkeeping	Monthly	Semiannual

I.15, I.16		12-Month Period Clinker Handled			

Conditions

I.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

I.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

I.3. Holcim shall operate and maintain a baghouse to control emissions from the emitting unit (ARM 17.8.749).

I.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

I.5. Holcim shall limit clinker handling to 500,000 tons during any rolling 12-month period (ARM 17.8.749).

Compliance Demonstration

I.6. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.I.1 by performing a Method 9 test as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

I.7. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.I.2 by performing a Method 5 test, or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

I.8. Holcim shall monitor compliance with Section III.I.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

I.9. Holcim shall monitor compliance with Section III.I.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

I.10. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.I.5. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

Recordkeeping

I.11. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

I.12. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

I.13. Holcim shall maintain records as required by Sections III.I.9 and III.I.10 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

I.14. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

I.15. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

I.16. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Sections III.I.3 and III.I.8;

c. Certification that the documents required in Section III.I.9 were maintained; and

d. A summary of the amount of clinker handled during the semiannual period.

J. Emitting Units – EU024 Clinker Storage Silos #1 and #2 & Interstice Bin Load/Unload
EU027 Outside Clinker Bins Loading
EU033 Clinker Transfer to #2 Finish Mill & #3 Finish Mill
EU035 Clinker Transfer to #4 Finish Mill
EU041 Gypsum Unloading and Transfer
EU043 Outside Clinker Transfer to Reclaim Building

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
J.1, J.5, J.9, J.10, J.12, J.13, J.14	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
J.2, J.6, J.9, J.10, J.12, J.13, J.14	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
J.3, J.7, J.11, J.13, J.14	Emission Control Equipment	Operation and Maintenance of Emission Control	Covers and Enclosures	Whenever Process Equipment is	Semiannual

		Equipment		Operating	
J.4, J.8, J.11, J.13, J.14	Operational Limit	500,000 tons/rolling 12-Month Period Clinker Handled	Recordkeeping	Monthly	Semiannual

Conditions

J.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

J.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

J.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

J.4. Holcim shall limit clinker handling to 500,000 tons during any rolling 12-month period (ARM 17.8.749).

Compliance Demonstration

J.5. Holcim shall monitor compliance with Section III.J.1 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

J.6. Holcim shall monitor compliance with Section III.J.2 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 5 test or another test method approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

J.7. Holcim shall monitor compliance with Section III.J.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

J.8. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.J.4. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

Recordkeeping

J.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

J.10. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse(s) in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

J.11. Holcim shall maintain records as required by Sections III.J.7 and III.J.8 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

J.12. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

J.13. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

J.14. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Section III.J.6;

c. Certification that the documents required in Section III.J.7 were maintained; and

d. A summary of clinker handled during the semiannual period.

K. Emitting Unit – EU025 Cement Kiln Dust Silo Loading

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
K.1, K.5, K.9, K.12, K.13, K.14	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
K.2, K.6, K.9, K12, K13, K.14	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
K.3, K.7, K.10, K.13, K.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
K.4, K.8, K.11, K.13, K.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

K.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

K.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

K.3. Holcim shall operate and maintain a baghouse to control emissions from the emitting unit (ARM 17.8.749).

K.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

K.5. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.K.1 by performing a Method 9 test as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

K.6. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.K.2 by performing a Method 5 test, or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

K.7. Holcim shall monitor compliance with Section III.K.3 by inspecting and maintaining the baghouse in accordance with Appendix E of this permit (ARM 17.8.1213).

K.8. Holcim shall monitor compliance with Section III.K.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

K.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

K.10. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

K.11. Holcim shall maintain records as required by Section III.K.8 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

K.12. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

K.13. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

K.14. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Sections III.K.3 and III.K.6; and

c. Certification that the documents required in Section III.K.7 and III.K.8 were maintained.

L. Emitting Units – EU026 Cement Kiln Dust Silo Unloading to Truck
EU028-031 Outside Clinker Storage Silos #1-#4
EU038 Dust Discharge Spout between Kiln and Precipitator
EU040 Import Clinker Unloading and Transfer
EU059 Post Consumer Recycled Glass Transfers
EU060 Overflow Gypsum Transfer to Ground
EU061 Overflow Gypsum Transfer to Reclaim Building

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
L.1, L.4, L.7, L.9, L.10, L.11	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
L.2, L.5, L.7, L.9, L.10, L.11	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
L.3, L.6, L.8, L.10, L.11	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

L.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

L.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} – 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

L.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

L.4. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.L.1 by performing a Method 9 test as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

L.5. Holcim shall monitor compliance with the particulate emission limitation contained in Section III.L.2 by performing a Method 5 test, or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

L.6. Holcim shall monitor compliance with Section III.L.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

L.7. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

L.8. Holcim shall maintain records as required by Section III.L.6 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

L.9. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

L.10. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

L.11. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period; and

b. Certification that the document required in Section III.L.6 was maintained.

M. Emission Unit – EU032 #2 Finish Mill

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
M.1, M.6, M.12, M.16, M.17, M.18	Opacity	10%	Method 9	Every 5 years	Semiannual
M1, M.7, M.12, M.16, M.17, M.18	Particulate Matter	0.02 gr/dscf	Method 5	Every 5 years	Semiannual
M.2, M.8, M.13, M.17, M.18	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
M.3, M.9, M.14, M.17, M.18	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

M.4, M.10, M.14, M.17, M.18	Operational Limit	245,280 tons/rolling 12-Month Period Clinker Handled	Recordkeeping	Monthly	Semiannual
M.5, M.11, M.15, M.17, M.18	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

M.1. Holcim shall not cause or authorize to be discharged into the atmosphere, from the Finish Mill #2 baghouse:

a. Particulate matter in excess of 0.02 gr/dscf (ARM 17.8.752); and

b. Visible emissions that exhibit an opacity of 10% or greater averaged over 6 consecutive minutes, as required by 40 CFR Part 60, Subpart F (ARM 17.8.340).

M.2. Holcim shall operate and maintain baghouse(s) to control emissions from the Finish Mill #2 sources listed below (ARM 17.8.752):

a. A replacement air slide;

b. The clinker/gypsum feed belt via a booster fan;

c. The Finish Mill #2;

d. The bucket elevator; and

e. The product separator.

M.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

M.4. Holcim shall limit clinker handling to 245,280 tons during any rolling 12-month period (ARM 17.8.749).

M.5. Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the emitting unit by following the CAM plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

M.6. Holcim shall monitor compliance with the 10% opacity limit contained in Section III.M.1.b by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

M.7. Holcim shall monitor compliance with the particulate emission limitation in Section III.M.1.a by performing a Method 5 test or another test method approved by the Department once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106, ARM 17.8.340, and ARM 17.8.1213).

M.8. Holcim shall monitor compliance with Section III.M.2 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

M.9. Holcim shall monitor compliance with Section III.M.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

M.10. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.M.4. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

M.11. Holcim shall monitor compliance with Section III.M.5 by monitoring emissions according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

M.12. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

M.13. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

M.14. Holcim shall maintain the records required by Sections III.M.9 and III.M.10 on site and submit the information to the Department upon request (ARM 17.8.1212).

M.15. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

M.16. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

M.17. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

M.18. The semiannual monitoring reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the documents required in Section III.M.9 were maintained;

c. A summary of the amount of clinker handled in the semiannual period; and

d. Certification that the CAM Plan contained in Appendix F of this permit was followed.

N. Emitting Unit – EU034 #3 Finish Mill

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
N.1, N.6, N.11, N.12, N.15, N.16, N.17	Opacity	40%	Method 9	Every 5 years	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
N.2, N.7, N.11, N.12, N.15, N.16, N.17	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	Every 5 years	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
N.3, N.8, N.13, N.16, N.17	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual
N.4, N.9, N.13, N.16, N.17	Operational Limit	245,280 tons/rolling 12-Month Period Clinker Handled	Recordkeeping	Monthly	Semiannual
N.5, N.10, N.14, N.16, N.17	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

N.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)).

N.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

N.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

N.4. Holcim shall limit clinker handling to 245,280 tons during any rolling 12-month period (ARM 17.8.749).

N.5. Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the emitting unit by following the CAM plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

N.6. Holcim shall monitor compliance with Section III.N.1 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, once every 5 years or according to another testing/monitoring schedule as may be approved by the Department, Holcim shall perform Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

N.7. Holcim shall monitor compliance with Section III.N.2 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, once every 5 years or according to another testing/monitoring schedule as may be approved by the Department, Holcim shall perform a Method 5 test or another Department approved test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

N.8. Holcim shall monitor compliance with Section III.N.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

N.9. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.N.4. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

N.10. Holcim shall monitor compliance with Section III.N.5 by monitoring emissions according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

N.11. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

N.12. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

N.13. Holcim shall maintain records as required by Sections III.N.8 and III.N.9 on site and submit the information to the Department upon request (ARM 17.8.1212).

N.14. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

N.15. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

N.16. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

N.17. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Sections III.N.6 and III.N.7;

c. Certification that the documents required in Section III.N.8 were maintained;

d. A summary of the amount of clinker handled in the semiannual period; and

e. Certification that the CAM Plan contained in Appendix F of this permit was followed.

O. Emitting Units – EU036 #4 Finish Mill Product Separator
EU037 #4 Finish Mill

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
O.1, O.7, O.13, O.17, O.18, O.19	Opacity	10%	Method 9	Every 5 years	Semiannual
O.2, O.8, O.13, O.17, O.18, O.19	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	Every 5 years	Semiannual
O.3, O.9, O.14, O.18, O.19	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
O.4, O.10, O.15, O.18, O.19	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual
O.5, O.11, O.15, O.18, O.19	Operational Limit	395,000 tons/rolling 12-Month Period Clinker Handled	Recordkeeping	Monthly	Semiannual
O.6, O.12, O.16, O.18, O.19	PM_{10} CAM Plan	CAM Plan Appendix F	CAM Plan Appendix F	Ongoing	Semiannual

Conditions

O.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the Finish Mill #4 visible emissions that exhibit an opacity of 10% or greater averaged over 6 consecutive minutes, as required by 40 CFR Part 60, Subpart F (ARM 17.8.340).

O.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

O.3. Holcim shall operate and maintain baghouse to control emissions from the emitting units (ARM 17.8.749).

O.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

O.5. Holcim shall limit clinker handling to 395,000 tons during any rolling 12-month period (ARM 17.8.749).

O.6. Holcim shall provide a reasonable assurance of compliance with the emission limitations or standards for the operation of the #4 Finish Mill (EU037) by following the CAM plan contained in Appendix F of this permit (ARM 17.8.1504).

Compliance Demonstration

O.7. Holcim shall monitor compliance with the 10% opacity limit in Section III.O.1 by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

O.8. Holcim shall monitor compliance with the particulate emission limitation in Section III.O.2 by performing a Method 5 test or another test method approved by the Department once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106, 17.8.340, and ARM 17.8.1213).

O.9. Holcim shall monitor compliance with Section III.O.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

O.10. Holcim shall monitor compliance with Section III.O.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

O.11. Holcim shall document, by month, the amount of clinker handled. By the 25th day of each month, Holcim shall total the amount of clinker handled during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.O.5. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

O.12. Holcim shall monitor compliance with Section III.O.6 by monitoring emissions from the #4 Finish Mill (EU037) according to the CAM Plan contained in Appendix F of this permit (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

O.13. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

O.14. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

O.15. Holcim shall maintain records as required by Sections III.O.10 and III.O.11 on site and submit the information to the Department upon request (ARM 17.8.1212).

O.16. Holcim shall maintain CAM applicable records in accordance with 40 CFR Part 64 and the CAM Plan contained in Appendix F of this permit (ARM 17.8.1212 and 40 CFR 64).

Reporting

O.17. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

O.18. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

O.19. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated, inspected, and maintained as required by Sections III.O.3 and III.O.9;

c. Certification that the documents required in Section III.O.10 were maintained;

d. A summary of the amount of clinker handled during the semiannual period; and

e. Certification that the CAM Plan contained in Appendix F of this permit was followed.

P. Emitting Units – EU044 Cement Loaded/Unloaded at Silos #1-#7, #10, #11, & #13 EU045 Cement Loaded/Unloaded at Silos #8, #9, & #12

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
P.1, P.4, P.7, P.8, P.10, P.11, P.12	Opacity	40%	Method 9	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
P.2, P.5, P.7, P.8, P.10, P.11, P.12	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
P.3, P.6, P.9, P.11, P.12	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

P.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 40% or greater averaged

over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

P.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

P.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

P.4. Holcim shall monitor compliance with Section III.P.1 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

P.5. Holcim shall monitor compliance with Section III.P.2 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 5 test or another test method approved by the Department in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

P.6. Holcim shall monitor compliance with Section III.P.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

P.7. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

P.8. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse(s) in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

P.9. Holcim shall maintain records as required by Section III.P.6 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

P.10. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

P.11. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

P.12. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse(s) were operated, inspected, and maintained as required by Section III.P.5; and

c. Certification that the document required in Section III.P.6 was maintained.

Q. Emitting Units – EU046 Cement Transferred From Silos #1 - #13 to Bulk Load Silos #14 - #25
EU0047 Cement Loaded/Unloaded at Silos #14 - #25
EU049 Bulk Cement Truck Transfer/Loadout #1
EU050 Bulk Cement Truck Transfer/Loadout #2
EU051 Bulk Cement Railcar Transfer/Loadouts #1 and #2
EU062CKD Recycle Dust Scoops

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
Q.1, Q.4, Q.7, Q.8, Q.10, Q.11, Q.12	Opacity	20%	Method 9	Every 5 years	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
Q.2, Q.5, Q.7, Q.8, Q.10, Q.11, Q.12	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	Every 5 years	Semiannual
			Operation and Maintenance of a Baghouse	Whenever Process Equipment is Operating	Semiannual
Q.3, Q.6, Q.9, Q.11, Q.12	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

Q.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

Q.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} - 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

Q.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749).

Compliance Demonstration

Q.4. Holcim shall monitor compliance with Section III.Q.1 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, once every 5 years or according to another testing/monitoring schedule as may be approved by the

Department, Holcim shall perform a Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

Q.5. Holcim shall monitor compliance with Section III.Q.2 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, once every 5 years or according to another testing/monitoring schedule as may be approved by the Department, Holcim shall perform a Method 5 test or another test method approved by the Department in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1213).

Q.6. Holcim shall monitor compliance with Section III.Q.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

Q.7. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

Q.8. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

Q.9. Holcim shall maintain records as required by Section III.Q.6 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

Q.10. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

Q.11. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

Q.12. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated and maintained as required by Section III.Q.5; and

c. Certification that the document required in Section III.Q.6 was maintained.

R. Emitting Unit – EU048 Cement Loaded/Unloaded at Silos #26 - #30

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
R.1, R.5, R.9, R.12, R.13,	Opacity	10%	Method 9	Every 5 years	Semiannual

R.14					
R.2, R.6, R.9, R.12, R.13, R.14	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	Every 5 years	Semiannual
R.3, R.7, R.10, R.13, R.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
R.4, R.8, R.11, R.13, R.14	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

R.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source, visible emissions that exhibit an opacity of 10% or greater averaged over 6 consecutive minutes, as required by 40 CFR Part 60, Subpart F (ARM 17.8.340).

R.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} – 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

R.3. Holcim shall operate and maintain baghouse to control emissions from the emitting units (ARM 17.8.749).

R.4. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749)

Compliance Demonstration

R.5. Holcim shall monitor compliance with the 10% opacity limit in Section III.R.1 by performing a Method 9 test once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

R.6. Holcim shall monitor compliance with the particulate emission limitation in Section III.R.2 by performing a Method 5 test, or another test method approved by the Department, once every 5 years or according to another testing/monitoring schedule as may be approved by the Department. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106, 17.8.340, and ARM 17.8.1213).

R.7. Holcim shall monitor compliance with Section III.R.3 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

R.8. Holcim shall monitor compliance with Section III.R.4 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

R.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

R.10. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

R.11. Holcim shall maintain records as required by Section III.R.8 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

R.12. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

R.13. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

R.14 The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was operated and maintained as required by Section III.R.7; and

c. Certification that the document required in Section III.R.8 was maintained.

S. Emission Unit – EU053 CKD and Flyash Transfers to/from Pozzolan Silo

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
S.1, S.5, S.10, S.13, S.14, S.15	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
S.1, S.6, S.10, S13, S14, S.15	Particulate Matter	0.02 gr/dscf	Method 5	As Required by the Department and Section III.A.1	Semiannual
S.2, S.7, S.11, S.12, S.14, S.15	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Operation and Maintenance of Baghouse	Whenever Process Equipment is Operating	Semiannual
S.3, S.8, S12, S14, S.15	Enclosures	Installation, Use, and Maintenance of Enclosures	Use and Maintenance	Whenever Process Equipment is Operating	Semiannual
S.4, S.9, S.12, S.14, S.15	Operational Limit	50,000 tons/rolling 12-Month Period Pozzolan Material Handled	Recordkeeping	Monthly	Semiannual

Conditions

S.1. Holcim shall not cause or authorize to be discharged into the atmosphere, from the pozzolan material silo baghouse:

a. Particulate matter in excess of 0.02 gr/dscf (ARM 17.8.752); and

b. Visible emissions that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.752).

S.2. Holcim shall operate and maintain baghouse(s) to control emissions from the pozzolan material silo (ARM 17.8.752).

S.3. Holcim shall use and maintain enclosures around the pozzolan material system components listed below (ARM 17.8.752):

a. Rotary feeder;

b. Weighbelt conveyor; and

c. Screw line (conveyor).

S.4. Holcim shall not use, in any rolling 12-month period, greater than 50,000 tons of pozzolan material in the pozzolan material system (ARM 17.8.752).

Compliance Demonstration

S.5. Holcim shall monitor compliance with the 20% opacity limit contained in Section III.S.1 by performing a Method 9 test as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

S.6. Holcim shall monitor compliance with the particulate emission limitation in Section III.S.1 by performing a Method 5 test or another test method approved by the Department, as required by the Department and Section III.A.1. The test methods and procedures shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106, 17.8.340, and ARM 17.8.1213).

S.7. Holcim shall monitor compliance with Section III.S.2 by inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit (ARM 17.8.1213).

S.8. Holcim shall monitor compliance with Section III.S.3 by documenting that enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

S.9. Holcim shall document, by month, the amount of pozzolan material used in the pozzolan material system. By the 25th day of each month, Holcim shall total the amount of pozzolan material used in the pozzolan material system during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.S.4. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

Recordkeeping

S.10. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site, and shall be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

S.11. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

S.12. Holcim shall maintain records as required by Section III.S.7, III.S.8 and III.S.9 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

S.13. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

S.14. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

S.15. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of any compliance test conducted during the last reporting period;

b. Certification that the baghouse was inspected and maintained as required by Section III.S.7;

c. Certification that the documents required in Section III.S.8 were maintained; and

d. A summary of the amount of pozzolan material used in the pozzolan material system for the semiannual period.

T. Emitting Unit – EU054 Landfilled Cement Kiln Dust (CKD) Handling

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
T.1, T.4, T.7, T.10, T.11	Opacity	20%	Water Spray	As Needed	Semiannual
T.2, T.5, T.8, T.10, T.11	Airborne Particulate Matter	Reasonable Precautions	Water and/or Chemical Dust Suppressants	As Needed	Semiannual
T.3, T.6, T.9, T.10, T.11	Operational Limit	85,000 Tons of Landfilled CKD/Rolling 12-Month Period	Recordkeeping	Monthly	Semiannual

Conditions

T.1. Holcim shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)),

T.2. Holcim shall not cause or authorize the use of any street, road, or parking lot without taking reasonable precautions to control emissions of airborne particulate matter (ARM 17.8.308(2)).

T.3. Holcim shall not handle more than 85,000 tons of landfilled CKD in any rolling 12-month period (ARM 17.8.752).

Compliance Demonstration

T.4. Holcim shall monitor compliance with Section III.T.1 by using water spray, as necessary, when handling landfilled CKD (ARM 17.8.752 and 17.8.1213).

T.5. Holcim shall monitor compliance with Section III.T.2 by treating all unpaved portions of the haul roads, access roads, parking lots, or the general plant area with water and/or chemical dust suppressant, as necessary (ARM 17.8.749).

T.6. Holcim shall document, by month, the amount CKD reclaimed from the landfill. By the 25th day of each month, Holcim shall total the amount of CKD reclaimed from the landfill during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation contained in Section III.T.3. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.1213).

Recordkeeping

T.7. Holcim shall maintain records that water spray was used, as necessary, when handling landfilled CKD. The records must include, but are not limited to, the date and time that water spray was used (ARM 17.8.1213).

T.8. Holcim shall maintain records that all unpaved portions of the haul roads, access roads, parking lots, or the general plant area were treated with water and/or chemical dust suppressant, as necessary. The records must include, but are not limited to, the date and time of the application of the water and/or chemical dust suppressant (ARM 17.8.1213).

T.9. Holcim shall maintain records as required by Sections III.T.6 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

T.10. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

T.11. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the water spray use when handling landfilled CKD for the semiannual period;

b. A summary of the water and/or chemical dust suppressant applications for the semiannual period; and

c. A summary of the amount of CKD reclaimed from the landfill for the semiannual period.

U. Emitting Unit – EU055 Material Handling System for Feeding the Finish Mills

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements

U.1, U.4, U.7, U.8, U.10, U.11, U.12	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse(s)	Whenever Process Equipment is Operating	Semiannual
U.2, U.5, U.8, U.11, U.12	Particulate Matter	$E = 55.0P^{0.11} - 40$	Method 5	As Required by the Department and Section III.A.1	Semiannual
			Operation and Maintenance of a Baghouse(s)	Whenever Process Equipment is Operating	
U.3, U.6, U.9, U.11, U.12	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

U.1. Holcim shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of airborne particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.308).

U.2. The particulate emissions from process weight shall not exceed the value calculated by $E = 55.0P^{0.11} – 40$, where E is the rate of emission in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

U.3. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749)

Compliance Demonstration

U.4. Holcim shall monitor compliance with Section III.U.1 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

U.5. Holcim shall monitor compliance with Section III.U.2 by operating, and inspecting and maintaining the baghouse(s) in accordance with Appendix E of this permit. In addition, as required by the Department and Section III.A.1, Holcim shall perform a Method 5 test, or another test method approved by the Department, in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

U.6. Holcim shall monitor compliance with Section III.U.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

U.7. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

U.8. Holcim shall maintain records of all inspection and maintenance activities performed on the baghouse in accordance with the requirements in Appendix E of this permit. All inspection and maintenance records must be available to the Department for inspection and must be submitted to the Department upon request (ARM 17.8.1212).

U.9. Holcim shall maintain records as required by Section III.U.6 and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

U.10. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

U.11. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

U.12. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of any compliance tests conducted during the last reporting period;

b. Certification that the document required in Sections III.U.6 and III.U.8 were maintained; and

V. Emitting Unit – EU042 Outside Clinker Transfer to Pile

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
V.1, V.3, V.5, V.7, V.8, V.9	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
V.2, V.4, V.6, V.7, V.8, V.9	Emission Control Equipment	Operation and Maintenance of Emission Control Equipment	Covers and Enclosures	Whenever Process Equipment is Operating	Semiannual

Conditions

V.1. Holcim shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of airborne particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.308).

V.2. When process equipment is operating, Holcim shall use and maintain, as they were intended, conveyor covers, transfer point covers, or structural enclosures surrounding process equipment (ARM 17.8.749)

Compliance Demonstration

V.3. Holcim shall monitor compliance with Section III.V.1 by conducting a Method 9 test, as required by the Department and Section III.A.1, in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and 17.8.1213).

V.4. Holcim shall monitor compliance with Section III.V.3 by documenting that conveyor covers, transfer point covers, or structural enclosures surrounding process equipment were maintained and in place during operation of process equipment. The records shall include all repair and maintenance activity to all conveyor covers, transfer point covers, or structural enclosures. The records must include, but are not limited to, the date, time, and action(s) taken for repair and maintenance (ARM 17.8.1213).

Recordkeeping

V.5. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, shall be maintained on site and must be submitted to the Department upon request (ARM 17.8.106 and ARM 17.8.1212).

V.6. Holcim shall maintain records as required by Section III.V.4 on site and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

V.7. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106).

V.8. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

V.9. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of any compliance tests conducted during the last reporting period; and

b. Certification that the document required in Section III.V.4 was maintained.

SECTION IV. NON-APPLICABLE REQUIREMENTS

Air Quality Administrative Rules of Montana (ARM) and Federal Regulations identified as not applicable to the facility or to a specific emissions unit at the time of the permit issuance are listed below (ARM 17.8.1214). The following list does not preclude the need to comply with any new requirements that may become applicable during the permit term.

A. Facility-Wide

The following table contains non-applicable requirements which are administrated by the Air Resources Management Bureau of the Department of Environmental Quality.

Rule Citation	Reason
ARM 17.8.320 ARM17.8.324	These rules are not applicable because the facility does not have the specific emissions unit cited in the rules.
ARM 17.8.321 ARM 17.8.331 ARM 17.8.332 ARM 17.8.333 ARM 17.8.334 ARM 17.8.323 ARM 17.8.610 40 CFR 57	These rules are not applicable because the facility is not listed in the source category cited in the rules.
40 CFR 55 40 CFR 59 40 CFR 60 Subpart B 40 CFR 60 Subparts C, Ca, Cb, Cc, Cd, and Ce 40 CFR 60 Subparts D, Da, Db, Dc 40CFR 60 Subpart E, Ea, Eb, and Ec 40 CFR 60 Subparts G, H, I, J 40 CFR 60 Subparts K, Ka, Kb 40 CFR 60 Subparts L-X 40 CFR 60 Subpart Z 40 CFR 60 Subparts AA-EE 40 CFR 60 Subparts GG-HH 40 CFR 60 Subparts KK-NN 40 CFR 60 Subparts PP-XX 40 CFR 60 Subparts AAA-BBB 40 CFR 60 Subparts DDD 40 CFR 60 Subparts FFF-LLL 40 CFR 60 Subparts NNN-WWW 40 CFR 60 Subparts AAAA-DDDD 40 CFR 60 Subpart HHHH 40 CFR 60 Appendix G 40 CFR 60 Appendix I 40 CFR 61 Subparts B-F 40 CFR 61 Subparts H-L 40 CFR 61 Subparts N-R 40 CFR 61 Subpart T 40 CFR 61 Subparts V-W 40 CFR 61 Subpart Y 40 CFR 61 Subpart BB 40 CFR 61 Subpart FF 40 CFR 61 Appendices A-E 40 CFR 63 Subparts F-J 40 CFR 63 Subparts L,O 40 CFR 63 Subpart Q-U 40 CFR 63 Subparts W-Y 40 CFR 63 Subparts AA-EE 40 CFR 63 Subparts GG-MM 40 CFR 63 Subparts OO-YY 40 CFR 63 Subparts CCC-EEE	These requirements are not applicable because the facility is not an affected source as defined in these regulations.

40 CFR 63 Subparts GGG-KKK 40 CFR 63 Subparts MMM-RRR 40 CFR 63 Subparts TTT-XXX 40 CFR 63 Subpart AAAA 40 CFR 63 Subparts CCCC-KKKK 40 CFR 63 Subparts MMMM-ZZZZ 40 CFR 63 Subparts AAAAA-TTTTT 40 CFR 68 40 CFR 79-80 40 CFR 85-99	
40 CFR 72 40 CFR 73 40CFR 74 40 CFR 75 40 CFR 76 40 CFR 77 40 CFR 78	These requirements are not applicable because the facility is not an affected source as defined by the acid rain regulations.
40 CFR 82 Subpart A 40 CFR 82 Subparts C-D 40 CFR 82 Subparts G-H	These rules refers to processes, equipment and/or activities that are not used at the facility

B. Emission Units

The permit application identified applicable requirements: non-applicable requirements for individual or specific emission units were not listed. The Department has listed all non-applicable requirements in Section IV.A, these requirements relate to each specific unit, as well as facility wide.

SECTION V. GENERAL PERMIT CONDITIONS

A. Compliance Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(a)-(c)&(e), §1206(6)(c)&(b)

1. The permittee must comply with all conditions of the permit. Any noncompliance with the terms or conditions of the permit constitutes a violation of the Montana Clean Air Act, and may result in enforcement action, permit modification, revocation and reissuance, or termination, or denial of a permit renewal application under ARM Title 17, Chapter 8, Subchapter 12.

2. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition.

3. It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit. If appropriate, this factor may be considered as a mitigating factor in assessing a penalty for noncompliance with an applicable requirement if the source demonstrates that both the health, safety or environmental impacts of halting or reducing operations would be more serious than the impacts of continuing operations, and that such health, safety or environmental impacts were unforeseeable and could not have otherwise been avoided.

4. The permittee shall furnish to the Department, within a reasonable time set by the Department (not to be less than 15 days), any information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit, or to determine compliance with the permit. Upon request, the permittee shall also furnish to the Department copies of those records that are required to be kept pursuant to the terms of the permit. This subsection does not impair or otherwise limit the right of the permittee to assert the confidentiality of the information requested by the Department, as provided in 75-2-105, MCA.

5. Any schedule of compliance for applicable requirements with which the source is not in compliance with at the time of permit issuance shall be supplemental to, and shall not sanction noncompliance with, the applicable requirements on which it was based.

6. For applicable requirements that will become effective during the permit term, the source shall meet such requirements on a timely basis unless a more detailed plan or schedule is required by the applicable requirement or the Department.

B. Certification Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1207 and §1213(7)(a)&(c)-(d)

1. Any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12, shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

2. Compliance certifications shall be submitted by February 15 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. Each certification must include the required information for the previous calendar year (i.e., January 1 – December 31).

3. Compliance certifications shall include the following:

   a. The identification of each term or condition of the permit that is the basis of the certification;

   b. The identification of the method(s) or other means used by the owner or operator for determining the status of compliance with each term and condition during the certification period, consistent with ARM 17.8.1212;

   c. The status of compliance with each term and condition for the period covered by the certification, *including whether compliance during the period was continuous or intermittent* (based on the method or means identified in ARM 17.8.1213(7)(c)(ii), as described above); and

   d. Such other facts as the Department may require to determine the compliance status of the source.

4. All compliance certifications must be submitted to the Environmental Protection Agency, as well as to the Department, at the addresses listed in the Notification Addresses Appendix of this permit.

C. Permit Shield

ARM 17.8, Subchapter 12, Operating Permit Program §1214(1)-(4)

1. The applicable requirements and non-federally enforceable requirements are included and specifically identified in this permit and the permit includes a precise summary of the requirements not applicable to the source. Compliance with the conditions of the permit shall be deemed compliance with any applicable requirements and any non-federally enforceable requirements as of the date of permit issuance.

2. The permit shield described in 1 above shall remain in effect during the appeal of any permit action (renewal, revision, reopening, or revocation and reissuance) to the Board of Environmental Review (Board), until such time as the Board renders its final decision.

3. Nothing in this permit alters or affects the following:

   a. The provisions of Sec. 7603 of the FCAA, including the authority of the administrator under that section;

   b. The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance;

   c. The applicable requirements of the Acid Rain Program, consistent with Sec. 7651g(a) of the FCAA;

   d. The ability of the administrator to obtain information from a source pursuant to Sec. 7414 of the FCAA;

   e. The ability of the Department to obtain information from a source pursuant to the Montana Clean Air Act, Title 75, Chapter 2, MCA;

   f. The emergency powers of the Department under the Montana Clean Air Act, Title 75, Chapter 2, MCA; and

g. The ability of the Department to establish or revise requirements for the use of Reasonably Available Control Technology (RACT) as defined in ARM Title 17, Chapter 8. However, if the inclusion of a RACT into the permit pursuant to ARM Title 17, Chapter 8, Subchapter 12, is appealed to the Board, the permit shield, as it applies to the source's existing permit, shall remain in effect until such time as the Board has rendered its final decision.

4. Nothing in this permit alters or affects the ability of the Department to take enforcement action for a violation of an applicable requirement or permit term demonstrated pursuant to ARM 17.8.106, Source Testing Protocol.

5. Pursuant to ARM 17.8.132, for the purpose of submitting a compliance certification, nothing in these rules shall preclude the use, including the exclusive use, of any credible evidence or information relevant to whether a source would have been in compliance. However, when compliance or noncompliance is demonstrated by a test or procedure provided by permit or other applicable requirements, the source shall then be presumed to be in compliance or noncompliance unless that presumption is overcome by other relevant credible evidence.

6. The permit shield will not extend to minor permit modifications or changes not requiring a permit revision (see Sections I & J).

7. The permit shield will extend to significant permit modifications and transfer or assignment of ownership (see Sections K & N).

D. Monitoring, Recordkeeping, and Reporting Requirements
ARM 17.8, Subchapter 12, Operating Permit Program §1212(2)&(3)

1. Unless otherwise provided in this permit, the permittee shall maintain compliance monitoring records that include the following information:

   a. The date, place as defined in the permit, and time of sampling or measurement;

   b. The date(s) analyses were performed;

   c. The company or entity that performed the analyses;

   d. The analytical techniques or methods used;

   e. The results of such analyses; and

   f. The operating conditions at the time of sampling or measurement.

2. The permittee shall retain records of all required monitoring data and support information for a period of at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. All monitoring data, support information, and required reports and summaries may be maintained in computerized form at the plant site if the information is made available to Department personnel upon request, which may be for either hard copies or computerized format. Strip-charts must be maintained in their original form at the plant site and shall be made available to Department personnel upon request.

3. The permittee shall submit to the Department, at the addresses located in the Notification Addresses Appendix of this permit, reports of any required monitoring by February 15 and August 15 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. The monitoring report submitted on February 15 of each year must include the required monitoring information for the period of July 1 through December 31 of the previous year. The monitoring report submitted on August 15 of each year must include the required monitoring information for the period of January 1 through June 30 of the current year. All instances of deviations from the permit requirements must be clearly identified in such reports. All required reports must be certified by a responsible official, consistent with ARM 17.8.1207.

E. Prompt Deviation Reporting

ARM 17.8, Subchapter 12, Operating Permit Program §1212(3)(c)

The permittee shall promptly report deviations from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken. To be considered prompt, deviations shall be reported as part of the routine reporting requirements under ARM 17.8.1212(3)(b) and, if applicable, in accordance with the malfunction reporting requirements under ARM 17.8.110, unless otherwise specified in an applicable requirement.

F. Emergency Provisions

ARM 17.8, Subchapter 12, Operating Permit Program §1201(13) and §1214(5), (6)&(8)

1. An "emergency" means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation and causes the source to exceed a technology-based emission limitation under this permit due to the unavoidable increases in emissions attributable to the emergency. An emergency shall not include noncompliance to the extent caused by improperly designed equipment, lack of reasonable preventive maintenance, careless or improper operation, or operator error.

2. An emergency constitutes an affirmative defense to an action brought for noncompliance with a technology-based emission limitation if the permittee demonstrates through properly signed, contemporaneous logs, or other relevant evidence, that:

   a. An emergency occurred and the permittee can identify the cause(s) of the emergency;

   b. The permitted facility was at the time being properly operated;

   c. During the period of the emergency the permittee took all reasonable steps to minimize levels of emissions that exceeded the emission standards or other requirements in the permit; and

   d. The permittee submitted notice of the emergency to the Department within 2 working days of the time when emission limitations were exceeded due to the emergency. This notice fulfills the requirements of ARM 17.8.1212(3)(c). This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.

3. These emergency provisions are in addition to any emergency, malfunction or upset provision contained in any applicable requirement.

G. Inspection and Entry

ARM 17.8, Subchapter 12, Operating Permit Program §1213(3)&(4)

1. Upon presentation of credentials and other requirements as may be required by law, the permittee shall allow the Department, the administrator, or an authorized representative (including an authorized contractor acting as a representative of the Department or the administrator) to perform the following:

   a. Enter the premises where a source required to obtain a permit is located or emissions-related activity is conducted, or where records must be kept under the conditions of the permit;

   b. Have access to and copy, at reasonable times, any records that must be kept under the conditions of the permit;

   c. Inspect at reasonable times any facilities, emission units, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the permit; and

   d. As authorized by the Montana Clean Air Act and rules promulgated thereunder, sample or monitor, at reasonable times, any substances or parameters at any location for the purpose of assuring compliance with the permit or applicable requirements.

2. The permittee shall inform the inspector of all workplace safety rules or requirements at the time of inspection. This section shall not limit in any manner the Department's statutory right of entry and inspection as provided for in 75-2-403, MCA.

H. Fee Payment

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(f) and ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation, and Open Burning Fees §505(3)-(5) (STATE ONLY)

1. The permittee must pay application and operating fees, pursuant to ARM Title 17, Chapter 8, Subchapter 5.

2. Annually, the Department shall provide the permittee with written notice of the amount of the fee and the basis for the fee assessment. The air quality operation fee is due 30 days after receipt of the notice, unless the fee assessment is appealed pursuant to ARM 17.8.511. If any portion of the fee is not appealed, that portion of the fee that is not appealed is due 30 days after receipt of the notice. Any remaining fee, which may be due after the completion of an appeal, is due immediately upon issuance of the Board's decision or upon completion of any judicial review of the Board's decision.

3. If the permittee fails to pay the required fee (or any required portion of an appealed fee) within 90 days of the due date of the fee, the Department may impose an additional assessment of 15% of the fee (or any required portion of an appealed fee) or $100, whichever is greater, plus interest on the fee (or any required portion of an appealed fee), computed at the interest rate established under 15-31-510(3), MCA.

I. Minor Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1226(3)&(11)

1. An application for a minor permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation, or deletion, and may reference any required information that has been previously submitted.

2. The permit shield under ARM 17.8.1214 will not extend to any minor modifications processed pursuant to ARM 17.8.1226.

J. Changes Not Requiring Permit Revision
ARM 17.8, Subchapter 12, Operating Permit Program §1224(1)-(3), (5)&(6)

1. The permittee is authorized to make changes within the facility as described below, provided the following conditions are met:

   a. The proposed changes do not require the permittee to obtain an air quality preconstruction permit under ARM Title 17, Chapter 8, Subchapter 7;

   b. The proposed changes are not modifications under Title I of the FCAA, or as defined in ARM Title 17, Chapter 8, Subchapters 8, 9, or 10;

   c. The emissions resulting from the proposed changes do not exceed the emissions allowable under this permit, whether expressed as a rate of emissions or in total emissions;

   d. The proposed changes do not alter permit terms that are necessary to enforce applicable emission limitations on emission units covered by the permit; and

   e. The facility provides the administrator and the Department with written notification at least 7 days prior to making the proposed changes.

2. The permittee and the Department shall attach each notice provided pursuant to 1.e above to their respective copies of this permit.

3. Pursuant to the conditions above, the permittee is authorized to make Section 502(b)(10) changes, as defined in ARM 17.8.1201(30), without a permit revision. For each such change, the written notification required under 1.e above shall include a description of the change within the source, the date on which the change will occur, any change in emissions, and any permit term or condition that is no longer applicable as a result of the change.

4. The permittee may make a change not specifically addressed or prohibited by the permit terms and conditions without requiring a permit revision, provided the following conditions are met:

   a. Each proposed change does not weaken the enforceability of any existing permit conditions;

   b. The Department has not objected to such change;

   c. Each proposed change meets all applicable requirements and does not violate any existing permit term or condition; and

   d. The permittee provides contemporaneous written notice to the Department and the administrator of each change that is above the level for insignificant emission units as defined in ARM 17.8.1201(22) and 17.8.1206(3), and the written notice describes each such change, including the date of the change, any change in emissions, pollutants emitted, and any applicable requirement that would apply as a result of the change.

5. The permit shield authorized by ARM 17.8.1214 shall not apply to changes made pursuant to ARM 17.8.1224(3) and (5), but is applicable to terms and conditions that allow for increases and decreases in emissions pursuant to ARM 17.8.1224(4).

K. Significant Permit Modifications
ARM 17.8, Subchapter 12, Operating Permit Program §1227(1), (3)&(4)

1. The modification procedures set forth in 2 below must be used for any application requesting a significant modification of this permit. Significant modifications include the following:

   a. Any permit modification that does not qualify as either a minor modification or as an administrative permit amendment;

   b. Every significant change in existing permit monitoring terms or conditions;

   c. Every relaxation of permit reporting or recordkeeping terms or conditions that limit the Department's ability to determine compliance with any applicable rule, consistent with the requirements of the rule; or

   d. Any other change determined by the Department to be significant.

2. Significant modifications shall meet all requirements of ARM Title 17, Chapter 8, including those for applications, public participation, and review by affected states and the administrator, as they apply to permit issuance and renewal, except that an application for a significant permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation or deletion.

3. The permit shield provided for in ARM 17.8.1214 shall extend to significant modifications.

L. Reopening for Cause
ARM 17.8, Subchapter 12, Operating Permit Program §1228(1)&(2)

This permit may be reopened and revised under the following circumstances:

1. Additional applicable requirements under the FCAA become applicable to the facility when the permit has a remaining term of 3 or more years. Reopening and revision of the permit shall be completed not later than 18 months after promulgation of the applicable requirement. No reopening is required under ARM 17.8.1228(1)(a) if the effective date of the applicable requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms or conditions have been extended pursuant to ARM 17.8.1220(12) or 17.8.1221(2);

2. Additional requirements (including excess emission requirements) become applicable to an affected source under the Acid Rain Program. Upon approval by the administrator, excess emission offset plans shall be deemed incorporated into the permit;

3. The Department or the administrator determines that the permit contains a material mistake or that inaccurate statements were made in establishing the emission standards or other terms or conditions of the permit; or

4. The administrator or the Department determines that the permit must be revised or revoked and reissued to ensure compliance with the applicable requirements.

M. Permit Expiration and Renewal
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(g), §1220(11)&(12), and §1205(2)(d)

1. This permit is issued for a fixed term of 5 years.

2. Renewal of this permit is subject to the same procedural requirements that apply to permit issuance, including those for application, content, public participation, and affected state and administrator review.

3. Expiration of this permit terminates the permittee's right to operate unless a timely and administratively complete renewal application has been submitted consistent with ARM 17.8.1221 and 17.8.1205(2)(d). If a timely and administratively complete application has been submitted, all terms and conditions of the permit, including the application shield, remain in effect after the permit expires until the permit renewal has been issued or denied.

4. For renewal, the permittee shall submit a complete air quality operating permit application to the Department not later than 6 months prior to the expiration of this permit, unless otherwise specified. If necessary to ensure that the terms of the existing permit will not lapse before renewal, the Department may specify, in writing to the permittee, a longer time period for submission of the renewal application. Such written notification must be provided at least 1 year before the renewal application due date established in the existing permit.

N. Severability Clause
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(i)&(l)

1. The administrative appeal or subsequent judicial review of the issuance by the Department of an initial permit under this subchapter shall not impair in any manner the underlying applicability of all applicable requirements, and such requirements continue to apply as if a final permit decision had not been reached by the Department.

2. If any provision of a permit is found to be invalid, all valid parts that are severable from the invalid part remain in effect. If a provision of a permit is invalid in one or more of its applications, the provision remains in effect in all valid applications that are severable from the invalid applications.

O. Transfer or Assignment of Ownership
ARM 17.8, Subchapter 12, Operating Permit Program §1225(2)&(4)

1. If an administrative permit amendment involves a change in ownership or operational control, the applicant must include in its request to the Department a written agreement containing a specific date for the transfer of permit responsibility, coverage and liability between the current and new permittee.

2. The permit shield provided for in ARM17.8.1214 shall not extend to administrative permit amendments.

P. Emissions Trading, Marketable Permits, Economic Incentives
ARM 17.8, Subchapter 12, Operating Permit Program §1226(2)

Notwithstanding ARM 17.8.1226(1) and (7), minor air quality operating permit modification procedures may be used for permit modifications involving the use of economic incentives, marketable permits, emissions trading, and other similar approaches, to the extent that such minor permit modification procedures are explicitly provided for in the Montana State Implementation Plan or in applicable requirements promulgated by the administrator.

Q. No Property Rights Conveyed
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(d)

This permit does not convey any property rights of any sort, or any exclusive privilege.

R. Testing Requirements
ARM 17.8, Subchapter 1, General Provisions §105

The permittee shall comply with ARM 17.8.105.

S. Source Testing Protocol
ARM 17.8, Subchapter 1, General Provisions §106

The permittee shall comply with ARM 17.8.106.

T. Malfunctions
ARM 17.8, Subchapter 1, General Provisions §110

The permittee shall comply with ARM 17.8.110.

U. Circumvention
ARM 17.8, Subchapter 1, General Provisions §111

The permittee shall comply with ARM 17.8.111.

V. Motor Vehicles
ARM 17.8, Subchapter 3, Emission Standards §325

The permittee shall comply with ARM 17.8.325.

W. Annual Emissions Inventory
ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation and Open Burning Fees §505 (STATE ONLY)

The permittee shall supply the Department with annual production and other information for all emission units necessary to calculate actual or estimated actual amount of air pollutants emitted during each calendar year. Information shall be gathered on a calendar-year basis and submitted to the Department by the date required in the emission inventory request, unless otherwise specified in this permit. Information shall be in the units required by the Department.

X. Open Burning
ARM 17.8, Subchapter 6, Open Burning §604, 605 and 606

The permittee shall comply with ARM 17.8.604, 605 and 606.

Y. Montana Air Quality Permits
ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §745 and 764 (ARM 17.8.745(1) and 764(1)(b) are STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

1. Except as specified, no person shall construct, install, alter or use any air contaminant source or stack associated with any source without first obtaining a permit from the Department or Board. A permit is not required for those sources or stacks as specified by ARM 17.8.744(1)(a)-(k).

2. The permittee shall comply with ARM 17.8.743, 744, 745, 748, and 764.

3. ARM 17.8.745(1) specifies de minimis changes as construction or changed conditions of operation at a facility holding an air quality preconstruction permit issued under Chapter 8 that does not increase the facility's potential to emit by more than 15 tons per year of any pollutant, except (STATE ENFORCEABLE ONLY until approved by the EPA as part of the SIP):

   a. Any construction or changed condition that would violate any condition in the facility's existing air quality preconstruction permit or any applicable rule contained in Chapter 8 is prohibited, except as provided in ARM 17.8.745(2);

   b. Any construction or changed conditions of operation that would qualify as a major modification under Subchapters 8, 9 or 10 of Chapter 8;

   c. Any construction or changed condition of operation that would affect the plume rise or dispersion characteristic of emissions that would cause or contribute to a violation of an ambient air quality standard or ambient air increment as defined in ARM 17.8.804;

   d. Any construction or improvement project with a potential to emit more than 15 tons per year may not be artificially split into smaller projects to avoid air quality preconstruction permitting; or

   e. Emission reductions obtained through offsetting within a facility are not included when determining the potential emission increase from construction or changed conditions of operation, unless such reductions are made federally enforceable.

4. Any facility making a de minimis change pursuant to ARM 17.8.745(1) shall notify the Department if the change would include a change in control equipment, stack height, stack diameter, stack gas temperature, source location or fuel specifications, or would result in an increase in source capacity above its permitted operation or the addition of a new emission unit. The notice must be submitted, in writing, 10 days prior to start up or use of the proposed de minimis change, or as soon as reasonably practicable in the event of an unanticipated circumstance causing the de minimis change, and must include the information requested in ARM 17.8.745(1) (STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP).

Z. National Emission Standard for Asbestos
40 CFR, Part 61, Subpart M

The permittee shall not conduct any asbestos abatement activities except in accordance with 40 CFR 61, Subpart M (National Emission Standard for Hazardous Air Pollutants for Asbestos).

AA. Asbestos
ARM 17.74, Subchapter 3, General Provisions and Subchapter 4, Fees

The permittee shall comply with ARM 17.74.301, *et seq*., and ARM 17.74.401, *et seq*. (State only)

BB. Stratospheric Ozone Protection – Servicing of Motor Vehicle Air Conditioners
40 CFR, Part 82, Subpart B

If the permittee performs a service on motor vehicles and this service involves ozone-depleting substance/refrigerant in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR 82, Subpart B.

CC. Stratospheric Ozone Protection – Recycling and Emission Reductions

40 CFR, Part 82, Subpart F

The permittee shall comply with the standards for recycling and emission reductions in 40 CFR 82, Subpart F, except as provided for MVACs in Subpart B:

1. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to §82.156;

2. Equipment used during the maintenance, service, repair or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to §82.158;

3. Persons performing maintenance, service, repair or disposal of appliances must be certified by an approved technical certification program pursuant to §82.161;

4. Persons disposing of small appliances, MVACs and MVAC-like (as defined at §82.152) appliances must comply with recordkeeping requirements pursuant to §82.166;

5. Persons owning commercial or industrial process refrigeration equipment must comply with the leak repair requirements pursuant to §82.156; and

6. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to §82.166.

DD. Emergency Episode Plan

The permittee shall comply with the requirements contained in Chapter 9.7 of the State of Montana Air Quality Control Implementation Plan.

Each major source emitting 100 tons per year located in a Priority I Air Quality Control Region, shall submit to the Department a legally enforceable Emergency Episode Action Plan (EEAP) that details how the source will curtail emissions during an air pollutant emergency episode. The industrial EEAP shall be in accordance with the Department's EEAP and shall be submitted according to a timetable developed by the Department, following Priority I reclassification.

EE. Definitions

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit, shall have the meaning assigned to them in the referenced regulations.

APPENDICES

Appendix A INSIGNIFICANT EMISSION UNITS

Disclaimer: The information in this appendix is not State or Federally enforceable, but is presented to assist Holcim, the permitting authority, inspectors, and the public.

Pursuant to ARM 17.8.1201(22)(a), an insignificant emission unit means any activity or emissions unit located within a source that: (i) has a potential to emit less than 5 tons per year of any regulated pollutant; (ii) has a potential to emit less than 500 pounds per year of lead; (iii) has a potential to emit less than 500 pounds per year of hazardous air pollutants listed pursuant to Sec. 7412 (b) of the FCAA; and (iv) is not regulated by an applicable requirement, other than a generally applicable requirement that applies to all emission units subject to Subchapter 12.

List of Insignificant Activities:

The following table of insignificant sources and/or activities were provided by Holcim. Because there are no requirements to update such a list, the emission units and/or activities may change from those specified in the table.

Emissions Unit ID	Description
EU002	Quarry Drilling
EU004	Limestone, Sand and Shale Removal
EU016	Coal Storage Piles
EU017	Coke Storage Piles
EU039	Transfer of Reclaimed Clinker to Ground
EU052	Fuel Tanks
EU056	Space Heating
EU057	Storage Pile for Finish Mill Material Handling System
EU058	Post Consumer Recycled Glass Piles
EU063	Emergency Generators

Appendix B DEFINITIONS and ABBREVIATIONS

"Act" means the Clean Air Act, as amended, 42 U.S. 7401, *et seq*.

"Administrative permit amendment" means an air quality operating permit revision that:

(a) Corrects typographical errors;

(b) Identifies a change in the name, address or phone number of any person identified in the air quality operating permit, or identifies a similar minor administrative change at the source;

(c) Requires more frequent monitoring or reporting by Holcim;

(d) Requires changes in monitoring or reporting requirements that the Department deems to be no less stringent than current monitoring or reporting requirements;

(e) Allows for a change in ownership or operational control of a source if the Department has determined that no other change in the air quality operating permit is necessary, consistent with ARM 17.8.1225; or

(f) Incorporates any other type of change which the Department has determined to be similar to those revisions set forth in (a)-(e), above.

"Applicable requirement" means all of the following as they apply to emission units in a source requiring an air quality operating permit (including requirements that have been promulgated or approved by the Department or the administrator through rule making at the time of issuance of the air quality operating permit, but have future-effective compliance dates, provided that such requirements apply to sources covered under the operating permit):

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree or judicial or administrative order entered into or issued by the Department, that is contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any federally enforceable term, condition or other requirement of any air quality preconstruction permit issued by the Department under Subchapters 7, 8, 9 and 10 of this chapter, or pursuant to regulations approved or promulgated through rule making under Title I of the FCAA, including parts C and D;

(c) Any standard or other requirement under Sec. 7411 of the FCAA, including Sec. 7411(d);

(d) Any standard or other requirement under Sec. 7412 of the FCAA, including any requirement concerning accident prevention under Sec. 7412(r)(7), but excluding the contents of any risk management plan required under Sec. 7412(r);

(e) Any standard or other requirement of the acid rain program under Title IV of the FCAA or regulations promulgated thereunder;

(f) Any requirements established pursuant to Sec. 7661c(b) or Sec. 7414(a)(3) of the FCAA;

(g) Any standard or other requirement governing solid waste incineration, under Sec. 7429 of the FCAA;

(h) Any standard or other requirement for consumer and commercial products, under Sec. 7511b(e) of the FCAA;

(i) Any standard or other requirement for tank vessels, under Sec. 7511b(f) of the FCAA;

(j) Any standard or other requirement of the regulations promulgated to protect stratospheric ozone under Title VI of the FCAA, unless the administrator determines that such requirements need not be contained in an air quality operating permit;

(k) Any national ambient air quality standard or increment or visibility requirement under part C of Title I of the FCAA, but only as it would apply to temporary sources permitted pursuant to Sec. 7661c(e) of the FCAA; or

(l) Any federally enforceable term or condition of any air quality open burning permit issued by the Department under Subchapter 6.

"Department" means the Montana Department of Environmental Quality.

"Excess Emissions" means any visible emissions from a stack or source, viewed during the visual surveys, that meets or exceeds 15% opacity (or 30% opacity if associated with a 40% opacity limit) during normal operating conditions.

"Emissions unit" means any part or activity of a stationary source that emits or has the potential to emit any regulated air pollutant or any pollutant listed under Sec. 7412(b) of the FCAA. This term is not meant to alter or affect the definition of the term "unit" for purposes of Title IV of the FCAA.

"FCAA" means the Federal Clean Air Act, as amended.

"Federally enforceable" means all limitations and conditions which are enforceable by the administrator, including those requirements developed pursuant to 40 CFR Parts 60 and 61, requirements within the Montana state implementation plan, and any permit requirement established pursuant to 40 CFR 52.21 or under regulations approved pursuant to 40 CFR Part 51, Subpart I, including operating permits issued under an EPA approved program that is incorporated into the Montana state implementation plan and expressly requires adherence to any permit issued under such program.

"Fugitive emissions" means those emissions which could not reasonably pass through a stack, chimney, vent, or other functionally equivalent opening.

"General air quality operating permit" or **"general permit"** means an air quality operating permit that meets the requirements of ARM 17.8.1222, covers multiple sources in a source category, and is issued in lieu of individual permits being issued to each source.

"Hazardous air pollutant" means any air pollutant listed as a hazardous air pollutant pursuant to Sec. 112(b) of the FCAA.

"Non-federally enforceable requirement" means the following as they apply to emission units in a source requiring an air quality operating permit:

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree, or judicial or administrative order entered into or issued by the Department, that is not contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any term, condition or other requirement contained in any air quality preconstruction permit issued by the Department under Subchapters 7, 8, 9 and 10 of this chapter that is not federally enforceable;

(c) Does not include any Montana ambient air quality standard contained in Subchapter 2 of this chapter.

"Permittee" means the owner or operator of any source subject to the permitting requirements of this subchapter, as provided in ARM 17.8.1204, that holds a valid air quality operating permit or has submitted a timely and complete permit application for issuance, renewal, amendment, or modification pursuant to this subchapter.

"Regulated air pollutant" means the following:

(a) Nitrogen oxides or any volatile organic compounds;

(b) Any pollutant for which a national ambient air quality standard has been promulgated;

(c) Any pollutant that is subject to any standard promulgated under Sec. 7411 of the FCAA;

(d) Any Class I or II substance subject to a standard promulgated under or established by Title VI of the FCAA; or

(e) Any pollutant subject to a standard or other requirement established or promulgated under Sec. 7412 of the FCAA, including but not limited to the following:

(i) Any pollutant subject to requirements under Sec. 7412(j) of the FCAA. If the administrator fails to promulgate a standard by the date established in Sec. 7412(e) of the FCAA, any pollutant for which a subject source would be major shall be considered to be regulated on the date 18 months after the applicable date established in Sec. 7412(e) of the FCAA;

(ii) Any pollutant for which the requirements of Sec. 7412(g)(2) of the FCAA have been met but only with respect to the individual source subject to Sec. 7412(g)(2) requirement.

"Responsible official" means one of the following:

(a) For a corporation: a president, secretary, treasurer, or vice-president of the corporation in charge of a principal business function, or any other person who performs similar policy or decision-making functions for the corporation, or a duly authorized representative of such person if the representative is responsible for the overall operation of one or more manufacturing, production, or operating facilities applying for or subject to a permit and either:

(i) The facilities employ more than 250 persons or have gross annual sales or expenditures exceeding $25 million (in second quarter 1980 dollars); or

(ii) The delegation of authority to such representative is approved in advance by the Department.

(b) For a partnership or sole proprietorship: a general partner or the proprietor, respectively.

(c) For a municipality, state, federal, or other public agency: either a principal executive officer or ranking elected official. For the purposes of this part, a principal executive officer of a federal agency includes the chief executive officer having responsibility for the overall operations of a principal geographic unit of the agency (e.g., a regional administrator of the environmental protection agency).

(d) For affected sources: the designated representative in so far as actions, standards, requirements, or prohibitions under Title IV of the FCAA or the regulations promulgated thereunder are concerned, and the designated representative for any other purposes under this subchapter.

Abbreviations:

ARM	Administrative Rules of Montana
ASTM	American Society of Testing Materials
BACT	Best Available Control Technology
BDT	bone dry tons
BTU	British Thermal Unit
CFR	Code of Federal Regulations
CO	carbon monoxide
DEQ	Department of Environmental Quality
dscf	dry standard cubic foot
dscfm	dry standard cubic foot per minute
EEAP	Emergency Episode Action Plan
EPA	U.S. Environmental Protection Agency
EPA Method	Test methods contained in 40 CFR 60, Appendix A
EU	emissions unit
FCAA	Federal Clean Air Act
gr	grains
HAP	hazardous air pollutant
IEU	insignificant emissions unit
Mbdft	thousand board feet
Method 5	40 CFR 60, Appendix A, Method 5
Method 9	40 CFR 60, Appendix A, Method 9
MMbdft	million board feet
MMBTU	million British Thermal Units
NOx	oxides of nitrogen
NO_2	nitrogen dioxide
O_2	oxygen
Pb	lead
PM	particulate matter
PM10	particulate matter less than 10 microns in size
psi	pounds per square inch
scf	standard cubic feet
SIC	Source Industrial Classification
SO_2	sulfur dioxide
SOx	oxides of sulfur
TPY	tons per year
U.S.C.	United States Code
VE	visible emissions
VOC	volatile organic compound

Appendix C NOTIFICATION ADDRESSES

Compliance Notifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

United States EPA
Air Program Coordinator
Region VIII, Montana Office
10 W. 15th Street, Suite 3200
Helena, MT 59626

Permit Modifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

Office of Partnerships and Regulatory Assistance
Air and Radiation Program
US EPA Region VIII 8P-AR
1595 Wynkoop Street
Denver, CO 80202-1129

Appendix D AIR QUALITY INSPECTOR INFORMATION

Disclaimer: The information in this appendix is not State or Federally enforceable, but is presented to assist Holcim, permitting authority, inspectors, and the public.

1. Direction to Plant:

Exit Interstate 90 at the Three Forks/Trident, Montana exit. Proceed north towards the Missouri River Headwaters Park. The facility is located north of the Headwaters Park with the main office located just east of the railroad tracks.

2. Safety Equipment Required:

Anyone entering the Holcim facility shall, at a minimum, have and utilize the following personnel protective equipment:

a. Hard Hat,
b. Safety Glasses,
c. Hearing Protection, and
d. Protective Footwear.

Additional personnel protective equipment may be required at the direction of a Holcim representative.

3. Facility Plot Plan:

A copy of the facility Plot Plan is on file with the Department or may be received by contacting a Holcim representative.

Appendix E POLLUTION CONTROL DEVICE INSPECTION AND MAINTENANCE PLAN

Although the hard copy of Appendix E has been removed from the permit, the contents of Appendix E, Pollution Control Device Inspection and Maintenance Plan, remain as applicable requirements as stated in the Title V Operating Permit #0982-02. To receive a hard copy of this appendix, please contact one of the following:

The Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
1520 E. Sixth Ave.
P.O. Box 200901
Helena, MT 59620-0901
Bureau Telephone # (406) 444-3490

OR

Holcim (US), Inc.
4070 Trident Road
Three Forks, MT 59752

Appendix F COMPLIANCE ASSURANCE MONITORING (CAM)

I. **Emitting Unit:** EU021 – Kiln
Pollutant: PM_{10}
Control Device: ESP
Emission Limit: 0.77 lb/ton Clinker
Monitoring Approach: Key elements of the monitoring approach for this CAM applicable emitting unit are contained in Table I. A complete CAM plan is contained in Holcim's application for Title V operating permit renewal (#0982-01) and is on file with the Department. Complete copies of this CAM plan are available from the Department upon request.

Table I	
A. General Criteria	
Indicator	ESP Power
Measurement Approach	Electrical power input is measured using a voltmeter and an ammeter. The total power (P) input to the ESP is the sum of the products of the secondary voltage (V) and current (I) in each field. ($P = V_1I_1 + V_2I_2$).
Indicator Range	Due to the nature of ESP's, only a lower end value will be established for power input. An excursion occurs if the hourly average power input drops below its respective hourly average indicator value. The indicator value will be established during a source test (See stack test below). An excursion triggers an inspection, corrective action, and a reporting requirement.
B. Performance Criteria	
Data Representativeness	The voltage and current are measured using the instrumentation (voltmeter and ammeter) specifically designed and installed on the ESP to measure and control the performance of the ESP..
Verification of Operational Status	Continuous monitoring of total ESP power input (kW).
Quality Assurance/Quality Control	Validate voltmeter and ammeter output on an annual basis in accordance with good engineering practices.
Monitoring Frequency	Continuous (at least every minute)
Data Collection Procedures	The secondary voltage monitor and current monitor will measure their respective values on a one minute or less basis. The plant will calculate a one-hour block kW arithmetic mean value based on the available values. The data will be permanently stored in the plant data historian.
Averaging Period	One-hour block average.
Stack Test/Monitoring Initiation	After Department approval of the CAM Plan, Holcim will schedule and conduct Method 5 testing to establish a suitable minimum power indicator value. The indicator value shall be 80% of the lowest average power (kW) applied to the ESP over the duration of any one run that resulted in emissions less than the emission limit during the afore mentioned test. The indicator value shall be established as expeditiously as practicable after Department approval (Department Decision on OP0982-01) but in no case shall the establishment of the indicator value prevent monitoring from beginning within 180 days after Department approval of the permit (ARM 17.8.1508(4)).

II. **Emitting Unit:** EU022 – Clinker Cooler
Pollutant: PM_{10}
Control Device: Baghouse
Emission Limit: $E = 55.0P^{0.11}-40$
Monitoring Approach: Key elements of the monitoring approach for this CAM applicable emitting unit are contained in Table II. A complete CAM plan is contained in Holcim's application for Title V operating permit renewal (#0982-01) and is on file with the Department. Complete copies of this CAM plan are available from the Department upon request.

Table II	
A. General Criteria	
Indicator	Baghouse differential pressure.
Measurement Approach	Inlet and outlet of the baghouse is monitored using a differential pressure transducer. The signal from the pressure transducer is recorded using a data acquisition system. One-minute differential pressure values collected will be summed and averaged every 24 hours.
Indicator Range	An excursion is defined as a daily average differential pressure of below 1.0 or above 10 inches of water pressure. An excursion triggers an inspection and possible corrective action.
B. Performance Criteria	
Data Representativeness	Pressure drop across the baghouse is measured across the tube sheet. The minimum accuracy of the device is ± 1 inch of water.
Verification of Operational Status	Pressure drop is continuously monitored and recorded.
Quality Assurance/Quality Control	Pressure transducer is calibrated in accordance with manufacturer's recommendations.
Monitoring Frequency	Every minute
Data Collection Procedures	Inlet and outlet of the baghouse is monitored using a differential pressure transducer. The signal from the pressure transducer is recorded using a data acquisition system. The data will be permanently stored in the plant data historian.
Averaging Period	24-hour
Monitoring Initiation	The monitoring shall commence as expeditiously as practicable after Department approval (Department Decision on OP0982-01) but no later than 180 days after Department approval of the permit (ARM 17.8.1508(4)).

III. **Emitting Units:** EU032, EU034, and EU037 – Finish Mills #2, #3, and #4
Pollutant: PM_{10}
Control Device: Pulse Jet Baghouses
Emission Limit: 0.02 gr/dscm (EU032 only), $E = 55.0P^{0.11}-40$ (EU034 and EU037 only)
Monitoring Approach: Key elements of the monitoring approach for this CAM applicable emitting unit are contained in Table III. A complete CAM plan is contained in Holcim's application for Title V operating permit renewal (#0982-01) and is on file with the Department. Complete copies of this CAM plan are available from the Department upon request.

Table III	
A. General Criteria	
Indicator	Baghouse differential pressure.
Measurement Approach	Inlet and outlet of the baghouses is monitored using a differential pressure transducer. The signal from the pressure transducer is recorded using a data acquisition system. One-minute differential pressure values collected will be summed and averaged every 24 hours.
Indicator Range	An excursion is defined as a daily average differential pressure of below 2.5 or above 10 inches of water pressure. An excursion triggers an inspection and possible corrective action.
B. Performance Criteria	
Data Representativeness	Pressure drop across the baghouses is measured across the tube sheet. The minimum accuracy of the device is ± 1 inch of water.
Verification of Operational Status	Pressure drop is continuously monitored and recorded.
Quality Assurance/Quality Control	Pressure transducer is calibrated in accordance with manufacturer's recommendations.
Monitoring Frequency	Every minute
Data Collection Procedures	Inlet and outlet of the baghouses is monitored using a differential pressure transducer. The signal from the pressure transducer is recorded using a data acquisition system. The data will be permanently stored in the plant data historian.
Averaging Period	24-hour
Monitoring Initiation	The monitoring shall commence as expeditiously as practicable after Department approval (Department Decision on OP0982-01) but no later than 180 days after Department approval of the permit (ARM 17.8.1508(4)).